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<p>(21) International Application Number: PCT/US99/04008 (22) International Filing Date: 24 February 1999 (24.02.99) (30) Priority Data: 60/075,947 25 February 1998 (25.02.98) US 60/092,319 9 July 1998 (09.07.98) US 60/097,733 24 August 1998 (24.08.98) US (71) Applicant: SLOAN-KETTERING INSTITUTE FOR CAN- CER RESEARCH [US/US]; 1275 York Avenue, New York, NY 10021 (US). (72) Inventors: DANISHERSKY, Samuel, J.; 22 Brayton Street, Englewood, NJ 07631 (US). BALOG, Aaron; Apartment 4M, 504 East 81st Street, New York, NY 10028 (US). BERTINATO, Peter; Apartment 16N, 504 E. 63rd Street, New York, NY 10021 (US). SU, Dai-Shi; Apartment 1G, 303 East 71st Street, New York, NY 10021 (US). CHOU, Ting-Chau; 5 Daisy Way, Paramus, NJ 07652 (US). MENG, DongFang; Apartment A, 312 East 66th Street, New York, NY 10021 (US). KAMENECKA, Ted; Apartment 4B, 310 East 66th Street, New York, NY 10021 (US). SORENSEN, Erik, J.; 13296 Kingsfield Court, San</p>	<p>Diego, CA 92130 (US). KUDUK, Scott; 219 Summermist Lane, Harleysville, PA 14398 (US). HARRIS, Christina; 504 East 63rd Street, Apt. 17N, New York, NY 10021 (US). ZHANG, Xiu-Guo; 344 East 62nd Street, Apt. 4, New York, NY 10021 (US). BERTINO, Joseph, R.; 117 Somerset Hills Drive, Branford, CT 06405 (US). (74) Agents: JORAN, A., David et al.; Kramer Levin Naftalis & Frankel LLP, 919 Third Avenue, New York, NY 10022 (US). (81) Designated States: AL, AM, AT, AU, AZ, BA, BB, BG, BR, BY, CA, CH, CN, CU, CZ, DE, DK, EE, ES, FI, GB, GE, GH, GM, HR, HU, ID, IL, IN, IS, JP, KE, KG, KP, KR, KZ, LC, LK, LR, LS, LT, LU, LV, MD, MG, MK, MN, MW, MX, NO, NZ, PL, PT, RO, RU, SD, SE, SG, SI, SK, SL, TJ, TM, TR, TT, UA, UG, UZ, VN, YU, ZW, ARIPO patent (GH, GM, KE, LS, MW, SD, SZ, UG, ZW), Eurasian patent (AM, AZ, BY, KG, KZ, MD, RU, TJ, TM), European patent (AT, BE, CH, CY, DE, DK, ES, FI, FR, GB, GR, IE, IT, LU, MC, NL, PT, SE), OAPI patent (BF, BJ, CF, CG, CI, CM, GA, GN, GW, ML, MR, NE, SN, TD, TG). Published <i>With international search report.</i> <i>Before the expiration of the time limit for amending the</i> <i>claims and to be republished in the event of the receipt of</i> <i>amendments.</i></p>	
<p>(54) Title: SYNTHESIS OF EPOTHILONES, INTERMEDIATES THERETO AND ANALOGUES THEROF (57) Abstract The present invention provides convergent processes for preparing epothilone A and B, desoxyepothilones A and B, and analogues thereof, useful in the treatment of cancer and cancer which has developed a multidrug-resistant phenotype. Also provided are intermediates useful for preparing said epothilones.</p>		

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**SYNTHESIS OF EPOTHILONES,
INTERMEDIATES THERETO AND ANALOGUES THEREOF**

This application is based on U.S. Provisional Applications Serial Nos. 60/075,947, 60/092,319, and 60/097,733, filed February 25, 1998, July 9, 1998, and August 24, 1998, respectively, the contents of which are hereby incorporated by reference into this application, and is a continuation-in-part of U.S. Serial No. 08/986,025, filed December 3, 1997, which was based on U.S. Provisional Applications Serial Nos. 60/032,282, 60/033,767, 60/047,566, 60/047,941, and 60/055,533, filed December 3, 1996, January 14, 1997, May 22, 1997, May 29, 1997, and August 13, 1997, respectively, the contents of which are hereby incorporated by reference into this application. This invention was made with government support under grants CA-28824, CA-39821, CA-GM 72231, GM-18248, CA-62948, and AI0-9355 from the National Institutes of Health, and grant CHE-9504805 from the National Science Foundation.

Field of the Invention

The present invention is in the field of epothilone macrolides. In particular, the present invention relates to processes for the preparation of epothilones A and B, desoxyepothilones A and B, and analogues thereof which are useful as highly specific, non-toxic anticancer therapeutics. In addition, the invention provides methods of inhibiting multidrug resistant cells. The present invention also provides novel compositions of matter which serve as intermediates for preparing the epothilones.

Throughout this application, various publications are referred to, each of which is hereby incorporated by reference in its entirety into this application to more fully describe the state of the art to which the invention pertains.

Background of the Invention

Epothilones A and B are highly active anticancer compounds isolated from the Myxobacteria of the genus *Sorangium*. The full structures of these compounds, arising from an x-ray crystallographic analysis were determined by Höfle. G. Höfle et al., *Angew. Chem. Int. Ed. Engl.*, 1996, 35, 1567. The total synthesis of the epothilones is an important goal for

several reasons. Taxol® is already a useful resource in chemotherapy against ovarian and breast cancer and its range of clinical applicability is expanding. G.I. Georg et al., *Taxane Anticancer Agents*; American Cancer Society: San Diego, 1995. The mechanism of the cytotoxic action of Taxol®, at least at the *in vitro* level, involves stabilization of microtubule assemblies. P.B. Schiff et al., *Nature (London)*, 1979, 277, 665. A series of complementary *in vitro* investigations with the epothilones indicated that they share the mechanistic theme of the taxoids, possibly down to the binding sites to their protein target. D.M. Bollag et al., *Cancer Res.*, 1995, 55, 2325. Moreover, the epothilones surpass Taxol® in terms of cytotoxicity and far surpass it in terms of *in vitro* efficacy against drug resistant cells. Since multiple drug resistance (MDR) is one of the serious limitations of Taxol® (L.M. Landino and T.L. MacDonald in *The Chemistry and Pharmacology of Taxol® and its Derivatives*, V. Farin, Ed., Elsevier: New York, 1995, ch. 7, p. 301), any agent which promises relief from this problem merits serious attention. Furthermore, formulating the epothilones for clinical use is more straightforward than Taxol®.

Accordingly, the present inventors undertook the total synthesis of the epothilones, and as a result, have developed efficient processes for synthesizing epothilones A and B, the corresponding desoxyepothilones, as well as analogues thereof. The present invention also provides novel intermediates useful in the synthesis of epothilones A and B and analogues thereof, compositions derived from such epothilones and analogues, purified compounds of epothilones A and B, and desoxyepothilones A and B, in addition to methods of use of the epothilone analogues in the treatment of cancer. Unexpectedly, certain epothilones have been found to be effective not only in reversing multi-drug resistance in cancer cells, both *in vitro* and *in vivo*, but have been determined to be active as collateral sensitive agents, which are more cytotoxic towards MDR cells than normal cells, and as synergistic agents, which are more active in combination with other cytotoxic agents, such as vinblastin, than the individual drugs would be alone at the same concentrations. Remarkably, the desoxyepothilones of the invention have exceptionally high specificity as tumor cytotoxic agents *in vivo*, more effective and less toxic to normal cells than the principal chemotherapeutics currently in use, including Taxol®, vinblastin, adriamycin and camptothecin.

Summary of the Invention

One object of the present invention is to provide processes for the preparation of epothilones A and B, and desoxyepothilones A and B, and related compounds useful as anticancer therapeutics. Another object of the present invention is to provide various compounds useful as intermediates in the preparation of epothilones A and B as well as analogues thereof.

A further object of the present invention is to provide synthetic methods for preparing

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such intermediates. An additional object of the invention is to provide compositions useful in the treatment of subjects suffering from cancer comprising any of the analogues of the epothilones available through the preparative methods of the invention optionally in combination with pharmaceutical carriers.

5 A further object of the invention is to provide methods of treating subjects suffering from cancer using any of the analogues of the epothilones available through the preparative methods of the invention optionally in combination with pharmaceutical carriers.

10 Brief Description of the Drawings

Figure 1(A) shows a retrosynthetic analysis for epothilone A and B.

Figure 1(B) provides synthesis of compound 11. (a) $t\text{-BuMe}_2\text{OTf}$, 2,6-lutidine, CH_2Cl_2 , 98%; (b) (1) DDQ, $\text{CH}_2\text{Cl}_2/\text{H}_2\text{O}$, 89%; (2) $(\text{COCl})_2$, DMSO, CH_2Cl_2 , -78°C ; then Et_3N , $-78^\circ\text{C} \rightarrow \text{rt}$, 90%; (c) $\text{MeOCH}_2\text{PPh}_3\text{Cl}$, $t\text{-BuOK}$, THF, $0^\circ\text{C} \rightarrow \text{rt}$, 86%; (d) (1) $p\text{-TsOH}$, dioxane/ H_2O , 50°C , 99%; (2) $\text{CH}_3\text{PPh}_3\text{Br}$, NaHMDS, PhCH_3 , $0^\circ\text{C} \rightarrow \text{rt}$, 76%; (e) $\text{Ph}(\text{OCOCF}_3)_2$, MeOH/THF, rt, 0.25 h, 92%.

Figure 2 provides key intermediates in the preparation of 12,13-*E*- and -*Z*-deoxyepothilones.

Figure 3(A) provides syntheses of key iodinated intermediates used to prepare hydroxymethylene- and hydroxypropylene-substituted epothilone derivatives.

Figure 3(B) provides methods of preparing hydroxymethylene- and hydroxypropylene-substituted epothilone derivatives, said methods being useful generally to prepare 12,13-*E* epothilones wherein R is methyl, ethyl, *n*-propyl, and *n*-hexyl from the corresponding *E*-vinyl iodides.

Figure 3(C) shows reactions leading to benzoylated hydroxymethyl-substituted desoxyepothilone and hydroxymethylene-substituted epothilone (epoxide).

Figure 4(A) provides synthesis of compound 19. (a) DHP, PPTS, CH_2Cl_2 , rt; (b) (1) $\text{Me}_3\text{SiCClLi}$, $\text{BF}_3\cdot\text{OEt}_2$, THF, -78°C ; (2) MOMCl, $i\text{-Pr}_2\text{NEt}$, $\text{Cl}(\text{CH}_2)_2\text{Cl}$, 55°C ; (3) PPTS, MeOH, rt; (c) (1) $(\text{COCl})_2$, DMSO, CH_2Cl_2 , -78°C ; then Et_3N , $-78^\circ\text{C} \rightarrow \text{rt}$; (2) MeMgBr , Et_2O , $0^\circ\text{C} \rightarrow \text{rt}$; (3) TPAP, NMO, 4Å mol. sieves, CH_2Cl_2 , $0^\circ\text{C} \rightarrow \text{rt}$; (d) 16, $n\text{-BuLi}$, THF, -78°C ; then 15, THF, $-78^\circ\text{C} \rightarrow \text{rt}$; (e) (1) *N*-iodosuccinimide, AgNO_3 , $(\text{CH}_3)_2\text{CO}$; (2) Cy_2BH , Et_2O , AcOH; (f) (1) PhSH , $\text{BF}_3\cdot\text{OEt}_2$, CH_2Cl_2 , rt; (2) Ac_2O , pyridine, 4-DMAP, CH_2Cl_2 , rt.

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Figure 4(B) presents synthesis of compound 1. (a) 11, 9-BBN, THF, rt; then $\text{PdCl}_2(\text{dppf})_2$, Cs_2CO_3 , Ph_3As , H_2O , DMF, 19, rt, 71%; (b) p-TsOH, dioxane/ H_2O , 50°C; (c) KHMDS, THF, -78°C, 51%; (d) (1) HF-pyridine, pyridine, THF, rt, 97%; (2) t-BuMe₂ SiOTf, 2,6-lutidine, CH_2Cl_2 , -25°C, 93%; (3) Dess-Martin periodinane, CH_2Cl_2 , 87%; (4) HF-pyridine, THF, rt, 99%; (e) dimethyldioxirane, CH_2Cl_2 , 0.5 h, -50°C, 45% ($\geq 20:1$).

Figure 5 shows a scheme of the synthesis of the "left wing" of epothilone A.

Figure 6 provides a scheme of an olefin metathesis route to epothilone A and other analogues.

Figure 7 illustrates a convergent strategy for a total synthesis of epothilone A (1) and the glycal cyclopropane solvolysis strategy for the introduction of geminal methyl groups.

Figure 8 provides an enantioselective synthesis of compound 15B.

Figure 9 shows the construction of epothilone model systems 20B, 21B, and 22B by ring-closing olefin metathesis.

Figure 10 illustrates a sedimentation test for natural, synthetic and desoxyepothilone A.

Figure 11 illustrates a sedimentation test for natural, synthetic and desoxyepothilone A after cold treatment at 4°C.

Figure 12 illustrates (A) structures of epothilones A (1) and B (2) and (B) of Taxol® (1A).

Figure 13 shows a method of elaborating acyclic stereochemical relationships based on dihydropyrone matrices.

Figure 14 shows the preparation of intermediate 4A.

Figure 15 shows an alternative enantioselective synthesis of compound 17A.

Figure 16 provides a synthetic pathway to intermediate 13C. (a) 1. tributyl allyltin, (S)-(-)-BINOL, $\text{Ti}(\text{O}i\text{-Pr})_4$, CH_2Cl_2 , -20 °C, 60%, >95% e.e.; 2. Ac_2O , Et_3N , DMAP, CH_2Cl_2 , 95%; (b) 1. OsO_4 , NMO, acetone/ H_2O , 0°C; 2. NaIO_4 , THF/ H_2O ; (c) 12, THF, -20 °C, Z isomer only, 25% from 10; (d) $\text{Pd}(\text{dppf})_2$, Cs_2CO_3 , Ph_3As , H_2O , DMF, rt, 77%.

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Figure 17 provides a synthetic pathway to intermediate epothilone B (2). (a) *p*-TsOH, dioxane/H₂O, 55 °C, 71%; (b) KHMDS, THF, -78 °C, 67%, α/β: 1.5:1; (c) Dess-Martin periodinane, CH₂Cl₂; (d) NaBH₄, MeOH, 67% for two steps; (e) 1. HF-pyridine, pyridine, THF, rt, 93%; 2. TBSOTf, 2,6-lutidine, CH₂Cl₂, -30 °C, 89%; 3. Dess-Martin periodinane, CH₂Cl₂, 67%; (f) HF-pyridine, THF, rt, 80%; (g) dimethyldioxirane, CH₂Cl₂, -50 °C, 70%.

Figure 18 provides a synthetic pathway to a protected intermediate for 8-desmethyl deoxyepothilone A.

Figure 19 provides a synthetic pathway to 8-desmethyl deoxyepothilone A, and structures of *trans*-8-desmethyl-desoxyepothilone A and a *trans*-iodoolefin intermediate thereto.

Figure 20 shows (top) structures of epothilones A and B and 8-desmethylepothilone and (bottom) a synthetic pathway to intermediate TBS ester 10 used in the preparation of desmethylepothilone A. (a) (Z)-Crotyl-B[(-)-lpc]₂, -78 °C, Et₂O, then 3N NaOH, 30% H₂O₂; (b) TBSOTf, 2,6-lutidine, CH₂Cl₂ (74% for two steps, 87% ee); (c) O₃, CH₂Cl₂/MeOH, -78 °C, then DMS, (82%); (d) *t*-butyl isobutyrylacetate, NaH, BuLi, 0 °C, then 6 (60%, 10:1); (e) Me₄NBH(OAc)₃, -10 °C (50%, 10:1 α/β) or NaBH₄, MeOH, THF, 0 °C, (88%, 1:1 α/β); (f) TBSOTf, 2,6-lutidine, -40 °C, (88%); (g) Dess-Martin periodinane, (90%); (h) Pd(OH)₂, H₂, EtOH (96%); (i) DMSO, oxalyl chloride, CH₂Cl₂, -78 °C (78%); (j) Methyl triphenylphosphonium bromide, NaHMDS, THF, 0 °C (85%); (k) TBSOTf, 2,6-lutidine, CH₂Cl₂, rt (87%).

Figure 21 shows a synthetic pathway to 8-desmethylepothilone A. (a) Pd(dppf)₂Cl₂, Ph₃As, Cs₂CO₃, H₂O, DMF, rt (62%); (b) K₂CO₃, MeOH, H₂O (78%); (c) DCC, 4-DMAP, 4-DMAP-HCl, CHCl₃ (78%); (d) HF-pyr, THF, rt (82%); (e) 3,3-dimethyl dioxirane, CH₂Cl₂, -35 °C (72%, 1.5:1).

Figure 22 shows a synthetic pathway to prepare epothilone analogue 27D.

Figure 23 shows a synthetic pathway to prepare epothilone analogue 24D.

Figure 24 shows a synthetic pathway to prepare epothilone analogue 19D.

Figure 25 shows a synthetic pathway to prepare epothilone analogue 20D.

Figure 26 shows a synthetic pathway to prepare epothilone analogue 22D.

Figure 27 shows a synthetic pathway to prepare epothilone analogue 12-hydroxy ethyl-epothilone.

Figure 28 shows the activity of epothilone analogues in a sedimentation test in comparison with DMSO, epothilone A and/or B. Structures 17-20, 22, and 24-27 are shown in Figures 29-37, respectively. Compounds were added to tubulin (1mg/ml) to a concentration of 10 μ M. The quantity of microtubules formed with epothilone A was defined as 100%.

Figure 29 shows a high resolution ^1H NMR spectrum of epothilone analogue #17.

Figure 30 shows a high resolution ^1H NMR spectrum of epothilone analogue #18.

Figure 31 shows a high resolution ^1H NMR spectrum of epothilone analogue #19.

Figure 32 shows a high resolution ^1H NMR spectrum of epothilone analogue #20.

Figure 33 shows a high resolution ^1H NMR spectrum of epothilone analogue #22.

Figure 34 shows a high resolution ^1H NMR spectrum of epothilone analogue #24.

Figure 35 shows a high resolution ^1H NMR spectrum of epothilone analogue #25.

Figure 36 shows a high resolution ^1H NMR spectrum of epothilone analogue #26.

Figure 37 shows a high resolution ^1H NMR spectrum of epothilone analogue #27.

Figure 38 provides a graphical representation of the effect of fractional combinations of cytotoxic agents.

Figure 39 shows epothilone A and epothilone analogues #1-7. Potencies against human leukemia CCRF-CEM (sensitive) and CCRF-CEM/VBL MDR (resistant) sublines are shown in round and square brackets, respectively.

Figure 40 shows epothilone B and epothilone analogues #8-16. Potencies against human leukemia CCRF-CEM (sensitive) and CCRF-CEM/VBL MDR (resistant) sublines are shown in round and square brackets, respectively.

Figure 41 shows epothilone analogues #17-25. Potencies against human leukemia CCRF-CEM (sensitive) and CCRF-CEM/VBL MDR (resistant) sublines are shown in round and square brackets, respectively.

- 5 Figure 42(A) shows epothilone analogues #26-34. Potencies against human leukemia CCRF-CEM (sensitive) and CCRF-CEM/VBL MDR (resistant) sublines are shown in round and square brackets, respectively. (B) shows epothilone analogues #35-46. Potencies against human leukemia CCRF-CEM (sensitive) and CCRF-CEM/VBL MDR (resistant) sublines are shown in round and square brackets, respectively. (C) shows epothilone analogues #47-49.

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Figure 43(A) shows antitumor activity of desoxyepothilone B against MDR MCF-7/Adr xenograft in comparison with Taxol®. Control (◆); desoxyepothilone B (■; 35mg/kg); Taxol® (▲; 6mg/kg); adriamycin (×; 1.8mg/kg); i.p. Q2Dx5; start on day 8. (B) shows antitumor activity of epothilone B against MDR MCF-7/Adr xenograft in comparison with Taxol®. Control (◆);
 15 epothilone B (■; 25mg/kg; non-toxic dose); Taxol® (▲; 6mg/kg; half LD₅₀); adriamycin (×; 1.8mg/kg); i.p. Q2Dx5; start on day 8.

- Figure 44(A) shows toxicity of desoxyepothilone B in B6D2F₁ mice bearing B16 melanoma. Body weight was determined at 0, 2, 4, 6, 8, 10 and 12 days. Control (▲); desoxyepothilone
 20 B (○; 10mg/kg QDx8; 0 of 8 died); desoxyepothilone B (●; 20mg/kg QDx6; 0 of 8 died). Injections were started on day 1. (B) shows toxicity of epothilone B in B6D2F₁ mice bearing B16 melanoma. Body weight was determined at 0, 2, 4, 6, 8, 10 and 12 days. Control (▲); epothilone B (○; 0.4mg/kg QDx6; 1 of 8 died of toxicity); epothilone B (●; 0.8mg/kg QDx5; 5 of 8 died). Injections were started on day 1.

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Figure 45(A) shows comparative therapeutic effect of desoxyepothilone B and Taxol® on nude mice bearing MX-1 xenograft. Tumor, s.c.; drug administered i.p., Q2Dx5, start on day 7. control (◆); Taxol® (□; 5mg/kg, one half of LD₅₀); desoxyepothilone B (Δ; 25mg/kg; nontoxic dose). (B) shows comparative therapeutic effect of desoxyepothilone B and Taxol® on nude
 30 mice bearing MX-1 xenograft. Tumor, s.c.; drug administered i.p., Q2Dx5, start on day 7. control (◆); Taxol® (□; 5mg/kg, one half of LD₅₀, given on days 7, 9, 11, 13, 15; then 6 mg/kg, given on days 17, 19, 23, 24, 25); desoxyepothilone B (n=3; Δ, ×, *; 25mg/kg, nontoxic dose, given to three mice on days 7, 9, 11, 13, 15; then 35 mg/kg, given on days 17, 19, 23, 24, 25).

- 35 Figure 46 shows the effect of treatment with desoxyepothilone B (35 mg/kg), Taxol® (5 mg/kg) and adriamycin (2mg/kg) of nude mice bearing human MX-1 xenograft on tumor size between 8 and 18 days after implantation. Desoxyepothilone B (□), Taxol® (Δ), adriamycin (X), control

(◆); i.p. treatments were given on day 8, 10, 12, 14 and 16.

Figure 47 shows the relative toxicity of epothilone B (□; 0.6 mg/kg QDx4; i.p.) and desoxyepothilone B (Δ; 25 mg/kg QDx4; i.p.) versus control (◆) in normal nude mice. Body weight of mice was determined daily after injection. For epothilone B, 8 of 8 mice died of toxicity on days 5, 6, 6, 7, 7, 7, and 7; for desoxyepothilone B, all six mice survived.

Figure 48 shows a high resolution ¹H NMR spectrum of epothilone analogue #43.

Figure 49 shows a high resolution ¹H NMR spectrum of epothilone analogue #45.

Figure 50 shows a high resolution ¹H NMR spectrum of epothilone analogue #46.

Figure 51 shows a high resolution ¹H NMR spectrum of epothilone analogue #47.

Figure 52 shows a high resolution ¹H NMR spectrum of epothilone analogue #48.

Figure 53(A) shows an approach to the preparation of desoxyepothilones. (B) represents a key step involving dianion addition to an aldehyde reactant.

Figure 54 illustrates the acylation of t-butyl 4-methylpentan-3-yl-ate to provide t-butyl 4,4-dimethylheptan-3,5-dion-1-ate.

Figure 55 shows the preparation of a key intermediate hydroxyacid in the preparation of desoxyepothilones. The final synthetic steps leading to various desoxyepothilones from the hydroxyacid are found in, e.g., Figs. 21-26. R is selected from the group consisting of H, Me, Et, Pr, Hx, CH₂OH and (CH₂)₃OH. Ar is selected from the group consisting of phenyl, tolyl, xylyl, thiazolyl, 2-methylthiazolyl, pyrrol and pyridyl, and is either unsubstituted or substituted with an C₁₋₆ alkyl, phenyl or benzyl group. Conditions for the Noyori reduction are disclosed in Taber et al., *Tetrahedron Lett.*, **1991**, 32, 4227, and Noyori et al., *J. Amer. Chem. Soc.*, **1987**, 109, 5856, the contents of which are incorporated herein by reference. Conditions for the DDQ deprotection are disclosed in Horita et al., *Tetrahedron*, **1986**, 42, 3021, the contents of which is incorporated herein by reference.

Figure 56 illustrates an application of the Noyori reduction of a substrate with C-15 hydroxyl useful in the preparation of epothilone analogues.

Figure 57 exemplifies a dianion addition to a coupled aldehyde intermediate useful in the preparation of epothilone analogues.

5 Figure 58 provides an application of the Noyori reduction of a coupled substrate useful in the preparation of epothilone analogues.

Figure 59 shows the preparation of desoxyepothilone analogues by deoxygenation of the epoxide using Zn/Cu couple, exemplified by the conversion of desoxyepothilone B from epothilone B. In a sample procedure, Zn/Cu couple is added to a solution of epothilone B (6mg, 0.012 mmol) in i-PrOH (0.3 mL) and water (3 drops). The suspension was heated to 90°C for 13 hours, cooled to room temperature, filtered through a pad of Celite™ and concentrated. Flash chromatography afforded 1.5 mg of epothilone B (75% conversion) and 3.2 mg of desoxyepothilone B (73% yield, as a mixture of cis and trans isomers in a 0.7:1 ratio).

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Figure 60 illustrates the therapeutic effect of dEpoB, Taxol® and adriamycin in nude mice bearing the human mammary carcinoma MX-1 xenograft. MX-1 tissue preparation 100µl/mouse was implanted s.c. on day 0. Every other day i.p. treatments were given on day 8, 10, 12, 14 and 16 with dEpoB 35 mg/kg (■), Taxol® 5 mg/kg (▲), adriamycin (2 mg/kg (x), and vehicle (DMSO, 30µl) treated control (♦). For Taxol®, 2/10 mice died of toxicity on day 18. For adriamycin, 1/10 mice died of toxicity on day 22. For dEpoB, 10/10 mice survived and were subjected to the second cycle of treatment at 40 mg/kg on day 18, 20, 22, 24 and 26. This led to 3/10 mice tumor-free up to day 80, whereas 7/10 mice were with markedly suppressed tumors and were sacrificed on day 50.

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Figure 61(A) shows a procedure for preparing intermediate 49. ^aNaH, THF, 25°C, then 0°C, then propionyl chloride, -50°C, 71%; ^bNaH, 0°C then TESOTf, -50°C, 78%; LDA, THF, -33°C, 5 min.

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Figure 61(B) shows a procedure for preparing desoxyepothilone B. ^aTrocCl, pyridine, CH₂Cl₂, 0°C - 25°C; then 0.5N HCl in MeOH, 0°C, 87%; ^b9-BBN, THF, 50 then 51, (Pd(dppf)₂)Cl₂, Ph₃As, Cs₂CO₃, H₂O, DMF; ^c0.4N HCl in MeOH (50% for two steps); ^d(R)-(BINAP)RuCl₂, H₂ (1200 psi), MeOH, HCl, 25°C, 7 h, 88%, > 95:5; ^eTESOTf, 2,6-lutidine, CH₂Cl₂, -78-25°C, then HCl/MeOH, 77%; ^f2,4,6-trichlorobenzoyl chloride, TEA, 4-DMAP, toluene, 78%; ^gSml₂, cat. NiI₂, THF, -78°C, 95%; ^hHF·pyridine, THF, 98%; ⁱ2,2-dimethyldioxirane, CH₂Cl₂, -50°C, 98%, > 20:1.

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Figure 62 shows the therapeutic effect of dEpoB and Taxol® in nude mice bearing MX-1 with Q2Dx5 i.v. 6 h infusion, using dEpoB 30 mg/kg (x), Taxol® 15 mg/kg (■), Taxol® 24 mg/kg (Δ) and control (•).

- 5 Figure 63 shows the therapeutic effect of dEpoB and Taxol® in nude mice bearing MCF-7/Adr with Q2Dx5 i.v. 6 h infusion, using dEpoB 30 mg/kg (x), Taxol® 15 mg/kg (■), Taxol® 24 mg/kg (Δ) and control (•).

- Figure 64 shows the therapeutic effect of dEpoB and Taxol® in nude mice bearing CCRF/Taxol® with Q2Dx5 i.v. 6 h infusion, using dEpoB 30 mg/kg (x), Taxol® 20 mg/kg (■), Taxol® 24 mg/kg (Δ) and control (•). Treatment on days 6, 8, 10, 12 and 14.
- 10

Figure 65 (A) and (B) show a procedure for preparing desoxyepothilone B (14E).

- 15 Figure 66 (A) and (B) shows a procedure for preparing intermediate 8E.

Figure 67 shows the therapeutic effect of dEpoB and Taxol® in nude mice bearing CCRF/CEM tumor with Q2Dx4 i.v. 6 h infusion, using dEpoB 30 mg/kg (□), Taxol® 20 mg/kg (Δ), and control (◊). Treatment on days 21, 23, 25, and 27.

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Figure 68 shows the therapeutic effect of dEpoB and Taxol® in nude mice bearing CCRF/Taxol® with Q2Dx5 i.v. 6 h infusion, using dEpoB 30 mg/kg (□), Taxol® 20 mg/kg (Δ) and control (◊). Treatment on days 19, 21, 23, 25, 27, 39, 41, 43, 45 and 47.

- 25 Figure 69 shows the therapeutic effect of dEpoB and Taxol® in nude mice bearing SK-OV-3 Tumor with Q2Dx6 i.v. 6 h infusion, using dEpoB 30 mg/kg (Δ), Taxol® 15 mg/kg (□), and control (◊). Treatment on days 10, 12, 14, 16, 18 and 20.

- Figure 70 shows changes in body weight following treatment with desoxyepothilone B and Taxol® in nude mice bearing SK-OV-3 Tumor by i.v. infusion, using dEpoB 30 mg/kg (□), Taxol® 15 mg/kg (Δ) and control (◊).
- 30

- Figure 71 shows the therapeutic effect of dEpoB and Taxol® in nude mice bearing PC-3 Human Prostate Carcinoma with Q2Dx3 i.v. 6 or 18 h infusion, using dEpoB 30 mg/kg, 18 h (x), dEpoB 40 mg/kg, 6 h (*), dEpoB 50 mg/kg, 6 h (o) Taxol® 15 mg/kg, 6 h (□), Taxol® 24 mg/kg, 6 h (Δ) and control (♣). Treatment on days 5, 7 and 9.
- 35

Figure 72 shows the therapeutic effect of dEpoB and Taxol® in nude mice bearing CCRF-CEM/VBL with Q2Dx5 i.v. 6 h infusion, using dEpoB 30 mg/kg (□), Taxol® 20 mg/kg (Δ) and control (○). Treatment on days 19, 21, 23, 25, 27, 39, 41, 43, 45, 47 and 53.

- 5 Figure 73 shows the therapeutic effect of dEpoB and Taxol® in nude mice bearing HT-29 Colon Adenocarcinoma with Q2Dx6 i.v. 6 h infusion, using dEpoB 30 mg/kg (Δ), Taxol® 15 mg/kg (□) and control (○).

- 10 Figure 74 shows the therapeutic effect of dEpoB and Taxol® in nude mice bearing A549 Human Lung Carcinoma with Q2Dx3 i.v. 6 or 18 h infusion, using dEpoB 30 mg/kg 18h (x), dEpoB 40 mg/kg, 6 h (*), dEpoB 50 mg/kg, 6 h (o), Taxol® 15 mg/kg, 6 h (□), Taxol® 24 mg/kg, 6 h (Δ) and control (◆). Treatment on days 7, 9 and 11.

Figure 75 shows the Epi stability in plasma of dEpoB : human (Δ) and mice (●).

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Detailed Description of the Invention

- As used herein, the term "linear or branched chain alkyl" encompasses, but is not limited to, methyl, ethyl, propyl, isopropyl, t-butyl, sec-butyl, cyclopentyl or cyclohexyl. The alkyl group may contain one carbon atom or as many as fourteen carbon atoms, but preferably
25 contains one carbon atom or as many as nine carbon atoms, and may be substituted by various groups, which include, but are not limited to, acyl, aryl, alkoxy, aryloxy, carboxy, hydroxy, carboxamido and/or N-acylamino moieties.

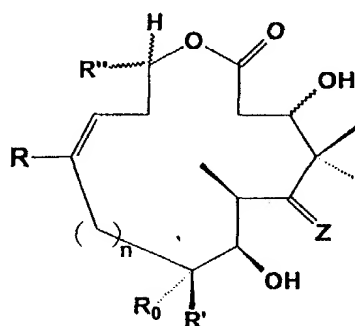
- As used herein, the terms "alkoxycarbonyl", "acyl" and "alkoxy" encompass, but are not limited to, methoxycarbonyl, ethoxycarbonyl, propoxycarbonyl, n-butoxycarbonyl,
30 benzyloxycarbonyl, hydroxypropylcarbonyl, aminoethoxycarbonyl, sec-butoxycarbonyl and cyclopentylloxycarbonyl. Examples of acyl groups include, but are not limited to, formyl, acetyl, propionyl, butyryl and penanoyl. Examples of alkoxy groups include, but are not limited to, methoxy, ethoxy, propoxy, n-butoxy, sec-butoxy and cyclopentylloxy.

- As used herein, an "aryl" encompasses, but is not limited to, a phenyl, pyridyl, pyrrol,
35 indolyl, naphthyl, thiophenyl or furyl group, each of which may be substituted by various groups, which include, but are not limited, acyl, aryl alkoxy, aryloxy, carboxy, hydroxy, carboxamido or N-acylamino moieties. Examples of aryloxy groups include, but are not

-12-

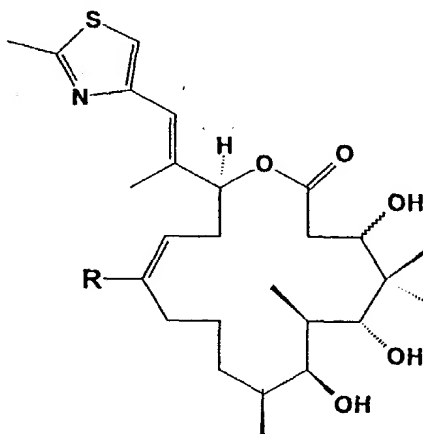
limited to, a phenoxy, 2-methylphenoxy, 3-methylphenoxy and 2-naphthoxy. Examples of acyloxy groups include, but are not limited to, acetoxy, propanoyloxy, butyryloxy, pentanoyloxy and hexanoyloxy.

The subject invention provides chemotherapeutic analogues of epothilone A and B,
5 including a compound having the structure:



wherein R, R₀, and R' are independently H, linear or branched chain alkyl, optionally
10 substituted by hydroxy, alkoxy, fluorine, NR₁R₂, N-hydroximino, or N-alkoxyimino, wherein
R₁ and R₂ are independently H, phenyl, benzyl, linear or branched chain alkyl; wherein R''
is -CHY=CHX, or H, linear or branched chain alkyl, phenyl, 2-methyl-1,3-thiazolyl, 2-
furanyl, 3-furanyl, 4-furanyl, 2-pyridyl, 3-pyridyl, 4-pyridyl, imidazolyl, 2-methyl-1,3-
oxazolyl, 3-indolyl or 6-indolyl; and wherein X is H, linear or branched chain alkyl, phenyl,
15 2-methyl-1,3-thiazolyl, 2-furanyl, 3-furanyl, 4-furanyl, 2-pyridyl, 3-pyridyl, 4-pyridyl,
imidazolyl, 2-methyl-1,3-oxazolyl, 3-indolyl or 6-indolyl; wherein Y is H or linear or
branched chain alkyl; wherein Z is O, N(OR₃) or N-NR₄R₅, wherein R₃, R₄ and R₅ are
independently H or a linear or branched alkyl; and wherein n is 0, 1, 2, or 3. In one
embodiment, the invention provides the compound having the structure:

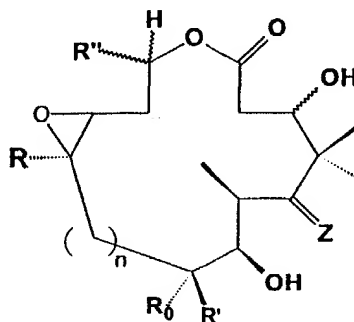
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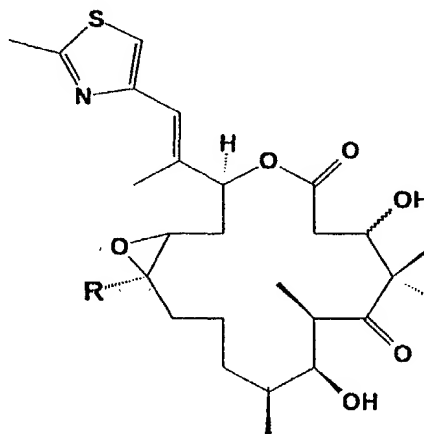
-13-

wherein R is H, methyl, ethyl, n-propyl, n-butyl, n-hexyl, CH₂OH, or (CH₂)₃OH.

The invention also provides a compound having the structure:



- 5 wherein R, R₀, and R' are independently H, linear or branched chain alkyl, optionally substituted by hydroxy, alkoxy, fluorine, NR₁R₂, N-hydroximino, or N-alkoxyimino, wherein R₁ and R₂ are independently H, phenyl, benzyl, linear or branched chain alkyl; wherein R'' is -CHY=CHX, or H, linear or branched chain alkyl, phenyl, 2-methyl-1,3-thiazolynyl, 2-furanyl, 3-furanyl, 4-furanyl, 2-pyridyl, 3-pyridyl, 4-pyridyl, imidazolyl, 2-methyl-1,3-oxazolynyl, 3-indolyl or 6-indolyl; and wherein X is H, linear or branched chain alkyl, phenyl, 2-methyl-1,3-thiazolynyl, 2-furanyl, 3-furanyl, 4-furanyl, 2-pyridyl, 3-pyridyl, 4-pyridyl, imidazolyl, 2-methyl-1,3-oxazolynyl, 3-indolyl or 6-indolyl; wherein Y is H or linear or branched chain alkyl; wherein Z is O, N(OR₃) or N-NR₄R₅, wherein R₃, R₄ and R₅ are independently H or a linear or branched chain alkyl; and wherein n is 0, 1, 2, or 3. In a certain embodiment, the invention provides a compound having the structure:

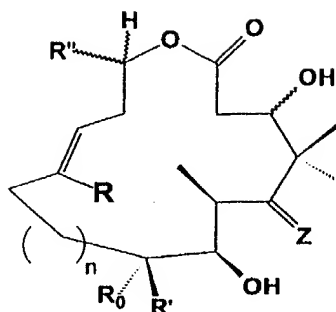


wherein R is H, methyl, ethyl, n-propyl, n-butyl, n-hexyl or CH₂OH.

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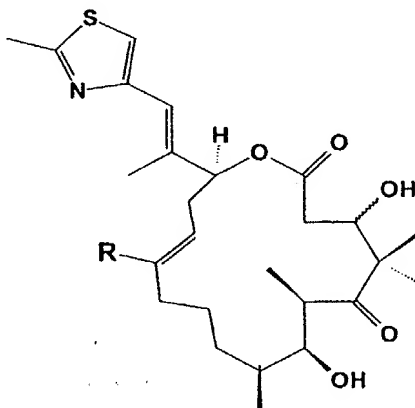
In addition, the invention provides a compound having the structure:

-14-



wherein R, R₀, and R' are independently H, linear or branched chain alkyl, optionally substituted by hydroxy, alkoxy, fluorine, NR₁R₂, N-hydroximino, or N-alkoxyimino, wherein R₁ and R₂ are independently H, phenyl, benzyl, linear or branched chain alkyl; wherein R'' is -CHY=CHX, or H, linear or branched chain alkyl, phenyl, 2-methyl-1,3-thiazoliny, 2-furanyl, 3-furanyl, 4-furanyl, 2-pyridyl, 3-pyridyl, 4-pyridyl, imidazolyl, 2-methyl-1,3-oxazoliny, 3-indolyl or 6-indolyl; and wherein X is H, linear or branched chain alkyl, phenyl, 2-methyl-1,3-thiazoliny, 2-furanyl, 3-furanyl, 4-furanyl, 2-pyridyl, 3-pyridyl, 4-pyridyl, imidazolyl, 2-methyl-1,3-oxazoliny, 3-indolyl or 6-indolyl; wherein Y is H or linear or branched chain alkyl; wherein Z is O, N(OR₃) or N-NR₄R₅, wherein R₃, R₄ and R₅ are independently H or a linear or branched chain alkyl; and wherein n is 0, 1, 2, or 3. In particular, the invention provides a compound having the structure:

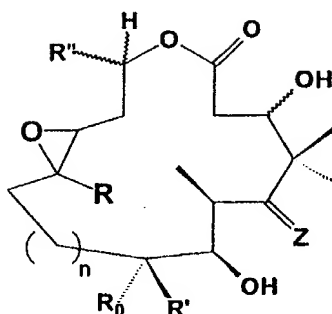
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wherein R is H, methyl, ethyl, n-propyl, n-butyl, CH₂OH or (CH₂)₃OH.

The invention further provides a compound having the structure:

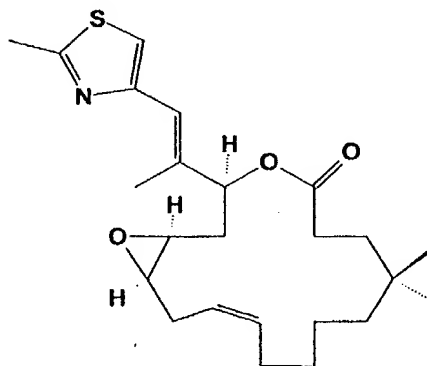
-15-



- wherein R , R_0 and R' are independently H, linear or branched chain alkyl, optionally substituted by hydroxy, alkoxy, fluorine, NR_1R_2 , N-hydroximino or N-alkoxyimino, wherein R_1 and R_2 are independently H, phenyl, benzyl, linear or branched chain alkyl; wherein R'' is $-CHY=CHX$, or H, linear or branched chain alkyl, phenyl, 2-methyl-1,3-thiazoliny, 2-furanyl, 3-furanyl, 4-furanyl, 2-pyridyl, 3-pyridyl, 4-pyridyl, imidazolyl, 2-methyl-1,3-oxazoliny, 3-indolyl or 6-indolyl; and wherein X is H, linear or branched chain alkyl, phenyl, 2-methyl-1,3-thiazoliny, 2-furanyl, 3-furanyl, 4-furanyl, 2-pyridyl, 3-pyridyl, 4-pyridyl, imidazolyl, 2-methyl-1,3-oxazoliny, 3-indolyl or 6-indolyl; wherein Y is H or linear or branched chain alkyl; wherein Z is O, $N(OR_3)$ or $N-NR_4R_5$, wherein R_3 , R_4 and R_5 are independently H or a linear or branched chain alkyl; and wherein n is 0, 1, 2 or 3.

The invention also provides a compound having the structure:

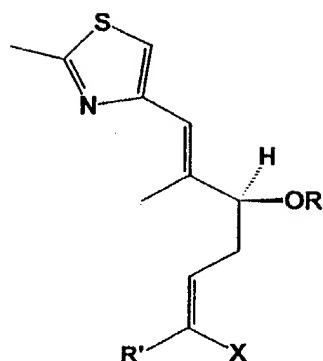
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- The subject invention also provides various intermediates useful for the preparation of the chemotherapeutic compounds epithilone A and B, as well as analogues thereof. Accordingly, the invention provides a key intermediate to epothilone A and its analogues having the structure:

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wherein R is hydrogen, a linear or branched acyl, substituted or unsubstituted aryl or

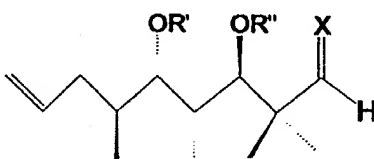
5 benzoyl; wherein R' is hydrogen, methyl, ethyl, n-propyl, n-hexyl,

CH₂OTBS or (CH₂)₃-OTBDPS; and X is a halide. In one embodiment, the subject

invention provides a compound of the above structure wherein R is acetyl and X is iodo.

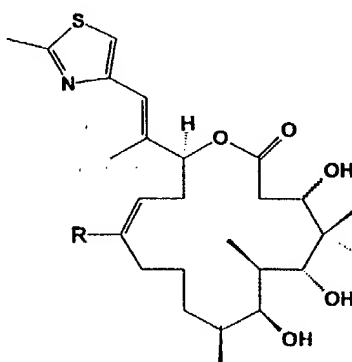
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The subject invention also provides an intermediate having the structure:



wherein R' and R'' are independently hydrogen, a linear or branched alkyl, substituted or unsubstituted aryl or benzyl, trialkylsilyl, dialkylarylsilyl, alkyldiarylsilyl, a linear or branched

15 acyl, substituted or unsubstituted aryl or benzoyl; wherein X is oxygen, (OR)₂, (SR)₂, -(O-(CH₂)_n-O)-, -(O-(CH₂)_n-S)- or -(S-(CH₂)_n-S)-; and wherein n is 2, 3 or 4.

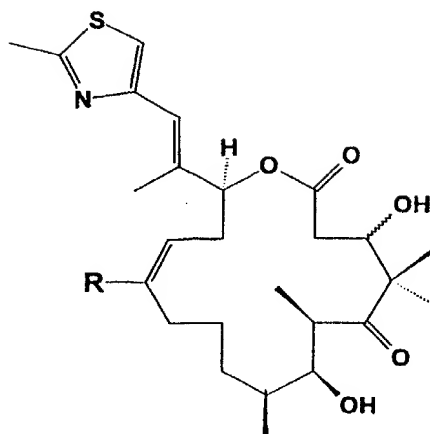


wherein R is H or methyl.

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Another analogue provided by the invention has the structure:

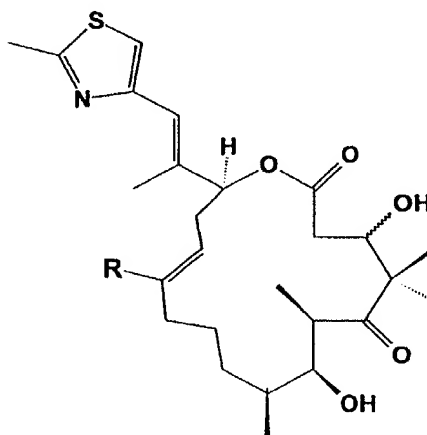
-17-



wherein R is H, methyl, ethyl, n-propyl, n-butyl, n-hexyl, CH₂OH, or (CH₂)₃OH..

Additionally, the subject invention provides an analogue having the structure:

5

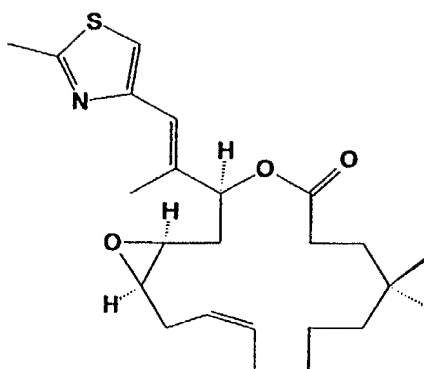


wherein R is H or methyl. The scope of the present invention includes compounds wherein the C₃ carbon therein possesses either an R or S absolute configuration, as well as mixtures thereof.

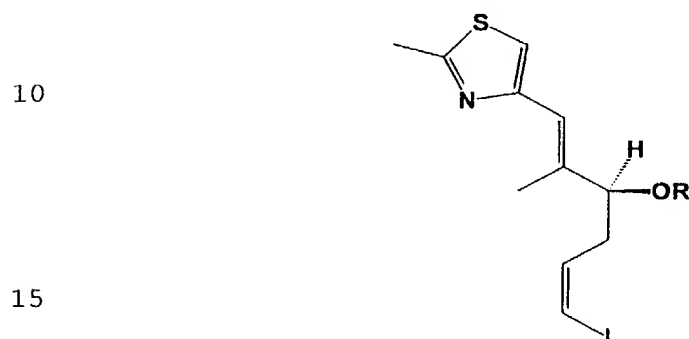
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The subject invention further provides an analogue of epothilone A having the structure:

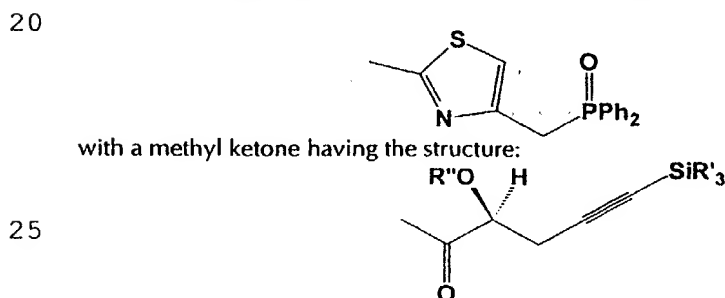
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The subject invention also provides synthetic routes to prepare the intermediates for preparing epothilones. Accordingly, the invention provides a method of preparing a Z-iodoalkene ester having the structure:

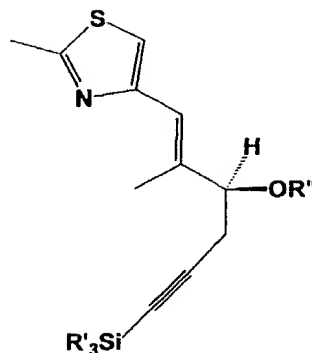


wherein R is hydrogen, a linear or branched alkyl, alkoxyalkyl, substituted or unsubstituted aryloxyalkyl, linear or branched acyl, substituted or unsubstituted aroyl or benzoyl, which comprises (a) coupling a compound having the structure:

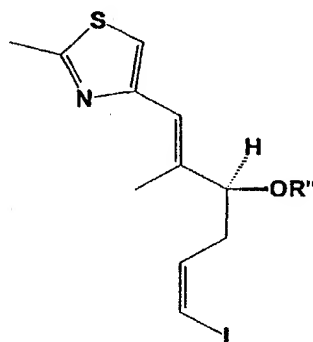


wherein R' and R'' are independently a linear or branched alkyl, alkoxyalkyl, substituted or unsubstituted aryl or benzyl, under suitable conditions to form a compound having the structure:

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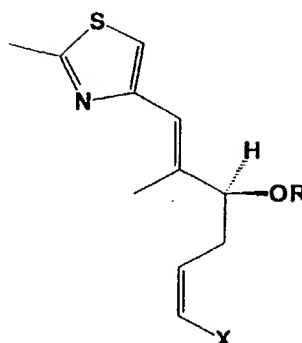
(b) treating the compound formed in step (a) under suitable conditions to form a Z-iodoalkene
 5 having the structure:



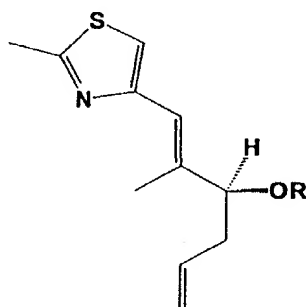
and (c) deprotecting and acylating the Z-iodoalkene formed in step (b) under suitable
 conditions to form the Z-iodoalkene ester. The coupling in step (a) may be effected using a
 strong base such as *n*-BuLi in an inert polar solvent such as tetrahydrofuran (THF) at low
 20 temperatures, typically below -50°C, and preferably at -78°C. The treatment in step (b) may
 comprise sequential reaction with N-iodosuccinimide in the presence of Ag(I), such as silver
 nitrate, in a polar organic solvent such as acetone, followed by reduction conditions, typically
 using a hydroborating reagent, preferably using Cy_2BH . Deprotecting step (c) involves
 contact with a thiol such as thiophenol in the presence of a Lewis acid catalyst, such as boron
 25 trifluoride-etherate in an inert organic solvent such as dichloromethane, followed by acylation
 with an acyl halide, such as acetyl chloride, or an acyl anhydride, such as acetic anhydride
 in the presence of a mild base such as pyridine and/or 4-dimethylaminopyridine (DMAP) in
 an inert organic solvent such as dichloromethane.

The subject invention also provides a method of preparing a Z-haloalkene ester
 30 having the structure:

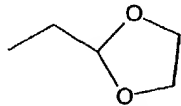
-20-



wherein R is hydrogen, a linear or branched alkyl, alkoxyalkyl, substituted or unsubstituted aryloxyalkyl, linear or branched acyl, substituted or unsubstituted aroyl or benzoyl; and
 5 wherein X is a halogen, which comprises (a) oxidatively cleaving a compound having the structure:



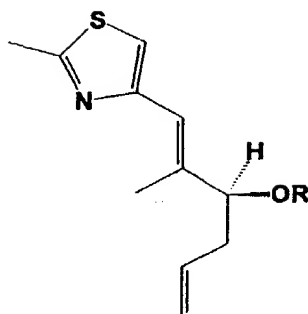
under suitable conditions to form an aldehyde intermediate; and (b) condensing the aldehyde
 10 intermediate with a halomethylene transfer agent under suitable conditions to form the Z-haloalkene ester. In one embodiment of the method, X is iodine. In another embodiment, the method is practiced wherein the halomethylene transfer agent is $\text{Ph}_3\text{P}=\text{CHI}$ or $(\text{Ph}_3\text{P}^+\text{CH}_2\text{I})\text{I}^-$. Disubstituted olefins may be prepared using the haloalkylidene transfer agent $\text{Ph}_3\text{P}=\text{CR}'\text{I}$,

wherein R' is hydrogen, methyl, ethyl, n-prop-yl, n-hexyl, , CO_2Et or

15 $(\text{CH}_2)_3\text{OTBDPS}$. The oxidative step (a) can be performed using a mild oxidant such as osmium tetroxide at temperatures of about 0°C , followed by treatment with sodium periodate, or with lead tetraacetate/sodium carbonate, to complete the cleavage of the terminal olefin, and provide a terminal aldehyde. Condensing step (b) occurs effectively with a variety of halomethylenating reagents, such as Wittig reagents.

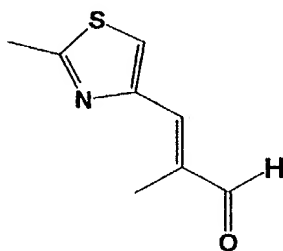
20 The subject invention further provides a method of preparing an optically pure compound having the structure:

-21-



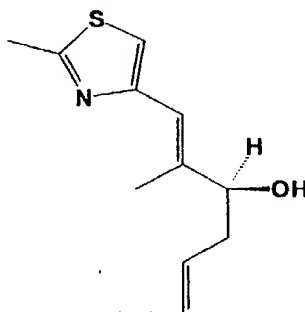
wherein R is hydrogen, a linear or branched alkyl, alkoxyalkyl, substituted or unsubstituted aryloxyalkyl, linear or branched acyl, substituted or unsubstituted aroyl or benzoyl, which

5 comprises: (a) condensing an allylic organometallic reagent with an unsaturated aldehyde having the structure:



under suitable conditions to form an alcohol, and, optionally concurrently therewith, optically

10 resolving the alcohol to form an optically pure alcohol having the structure:



(b) alkylating or acylating the optically pure alcohol formed in step (a) under suitable conditions to form the optically pure compound. In one embodiment of the method, the

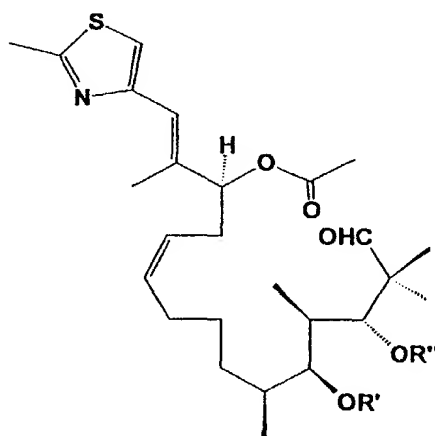
15 allylic organometallic reagent is an allyl(trialkyl)stannane. In another embodiment, the condensing step is effected using a reagent comprising a titanium tetraalkoxide and an optically active catalyst. In step (a) the 1,2-addition to the unsaturated aldehyde may be performed using a variety of allylic organometallic reagents, typically with an allyltrialkylstannane, and preferably with allyltri-n-butylstannane, in the presence of chiral

20 catalyst and molecular sieves in an inert organic solvent such as dichloromethane. Preferably,

- the method may be practiced using titanium tetraalkoxides, such as titanium tetra-*n*-propoxide, and *S*-(-)BINOL as the optically active catalyst. Alkylating or acylating step (b) is effected using any typical alkylating agent, such as alkylhalide or alkyl tosylate, alkyl triflate or alkyl mesylate, any typical acylating agent, such as acetyl chloride, acetic anhydride, benzoyl chloride or benzoyl anhydride, in the presence of a mild base catalyst in
- 5 an inert organic solvent, such as dichloromethane.

The subject invention also provides a method of preparing an open-chain aldehyde having the structure:

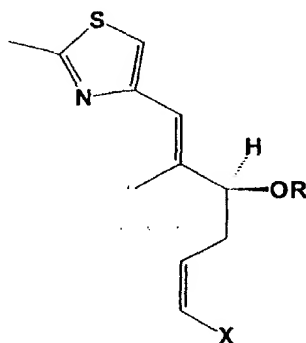
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wherein R' and R'' are independently hydrogen, a linear or branched alkyl, substituted or unsubstituted aryl or benzyl, trialkylsilyl, dialkylarylsilyl, alkyl diarylsilyl, a linear or branched acyl, substituted or unsubstituted aroyl or benzoyl, which comprises: (a) cross-coupling a

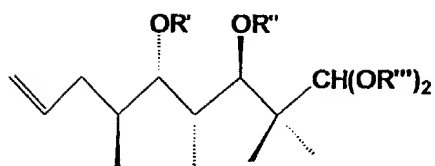
haloolefin having the structure:



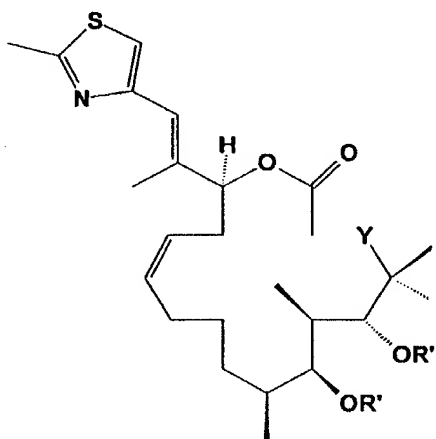
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wherein R is a linear or branched alkyl, alkoxyalkyl, substituted or unsubstituted aryloxyalkyl, trialkylsilyl, aryldialkylsilyl, diarylalkylsilyl, triarylsilyl, linear or branched acyl, substituted or unsubstituted aroyl or benzoyl, and X is a halogen, with a terminal olefin having the structure:

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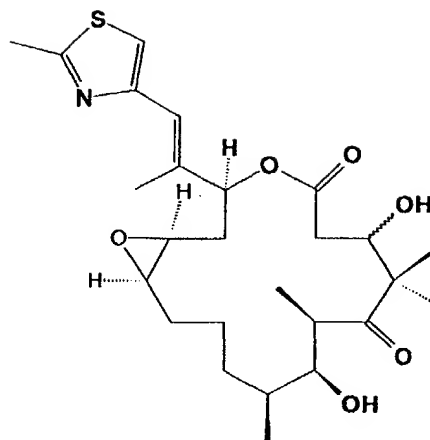
- wherein (OR''')₂ is (OR₀)₂, (SR₀)₂, -(O-(CH₂)_n-O)-, -(O-(CH₂)_n-S)- or -(S-(CH₂)_n-S)- where R₀ is a linear or branched alkyl, substituted or unsubstituted aryl or benzyl; and wherein n is 2, 3 or 4, under suitable conditions to form a cross-coupled compound having the structure:



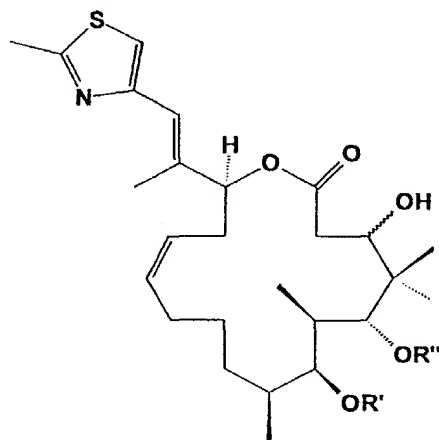
- wherein Y is CH(OR*)₂ where R* is a linear or branched alkyl, alkoxyalkyl, substituted or unsubstituted aryloxyalkyl; and (b) deprotecting the cross-coupled compound formed in step (a) under suitable conditions to form the open-chain compound. Cross-coupling step (a) is effected using reagents known in the art which are suited to the purpose. For example, the process may be carried out by hydroborating the pre-acyl component with 9-BBN. The resulting mixed borane may then be cross-coupled with an organometallic catalyst such as PdCl₂(dppf)₂, or any known equivalent thereof, in the presence of such ancillary reagents as cesium carbonate and triphenylarsine. Deprotecting step (b) can be carried out with a mild acid catalyst such as p-tosic acid, and typically in a mixed aqueous organic solvent system, such as dioxane-water. The open-chain compound can be cyclized using any of a variety of non-nucleophilic bases, such as potassium hexamethyldisilazide or lithium diethylamide.

The subject invention also provides a method of preparing an epothilone having the structure:

-24-

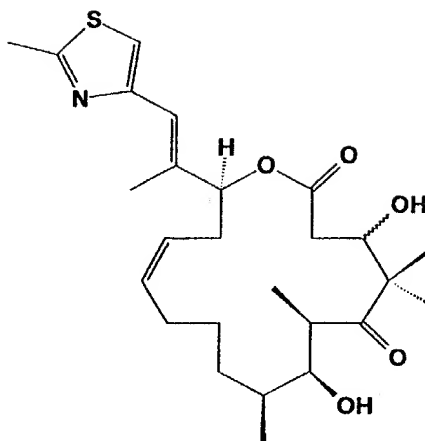


5 which comprises: (a) deprotecting a cyclized compound having the structure:



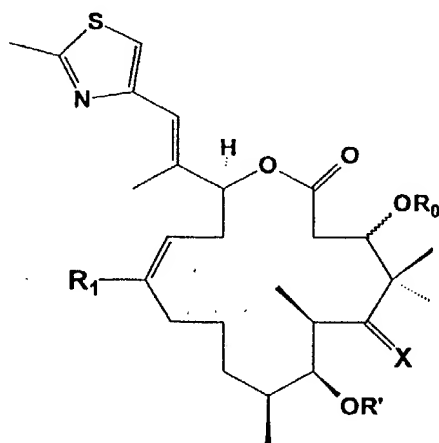
10 wherein R' and R'' are independently hydrogen, a linear or branched alkyl, substituted or unsubstituted aryl or benzyl, trialkylsilyl, dialkylarylsilyl, alkyl diarylsilyl, a linear or branched acyl, substituted or unsubstituted aroyl or benzoyl, under suitable conditions to form a deprotected cyclized compound and oxidizing the deprotected cyclized compound under suitable conditions to form a desoxyepothilone having the structure:

-25-



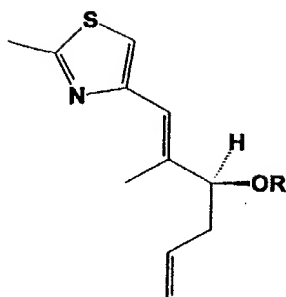
- and (b) epoxidizing the desoxyepothilone formed in step (a) under suitable conditions to form the epothilone. Deprotecting step (a) is effected using a sequence of treatments comprising a catalyst such as HF-pyridine, followed by t-butyldimethylsilyl triflate in the presence of a base such as lutidine. Dess-Martin oxidation and further deprotection with a catalyst such as HF-pyridine provides the desoxyepothilone. The latter compound can then be epoxidized in step (b) using any of a variety of epoxidizing agents, such as acetic peracid, hydrogen peroxide, perbenzoic acid, m-chloroperbenzoic acid, but preferably with dimethyldioxirane, in an inert organic solvent such as dichloromethane.

The subject invention further provides a method of preparing an epothilone precursor having the structure:

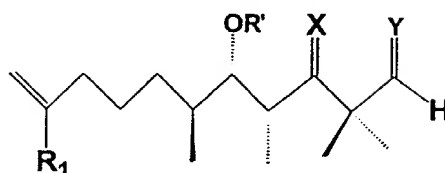


- wherein R₁ is hydrogen or methyl; wherein X is O, or a hydrogen and OR', each singly bonded to carbon; and wherein R₀, R' and R'' are independently hydrogen, a linear or branched alkyl, substituted or unsubstituted aryl or benzyl, trialkylsilyl, dialkylarylsilyl, alkylarylsilyl, a linear or branched acyl, substituted or unsubstituted aroyl or benzoyl, which comprises (a) coupling a compound having the structure:

-26-

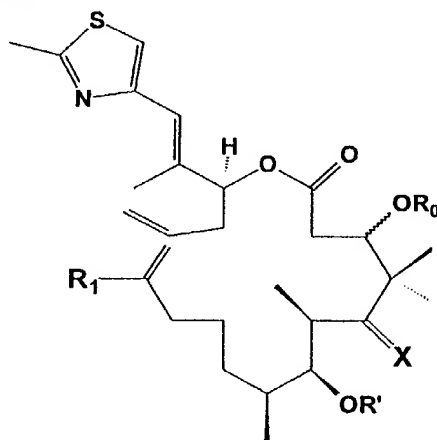


wherein R is an acetyl, with an aldehyde having the structure:



5

wherein Y is oxygen, under suitable conditions to form an aldol intermediate and optionally protecting the aldol intermediate under suitable conditions to form an acyclic ephthilone precursor having the structure:



10

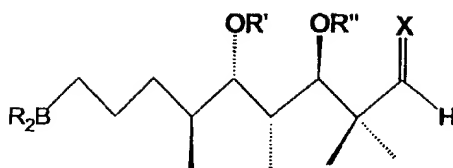
(b) subjecting the acyclic ephthilone precursor to conditions leading to intramolecular olefin metathesis to form the ephthilone precursor. In one embodiment of the method, the conditions leading to intramolecular olefin metathesis require the presence of an organometallic catalyst. In a certain specific embodiment of the method, the catalyst contains Ru or Mo. The coupling step (a) may be effected using a nonnucleophilic base such as lithium diethylamide or lithium diisopropylamide at subambient temperatures, but preferably at about -78°C. The olefin metathesis in step (b) may be carried out using any catalyst known in the art suited for the purpose, though preferably using one of Grubbs's catalysts.

15

In addition, the present invention provides a compound useful as an intermediate for preparing ephthilones having the structure:

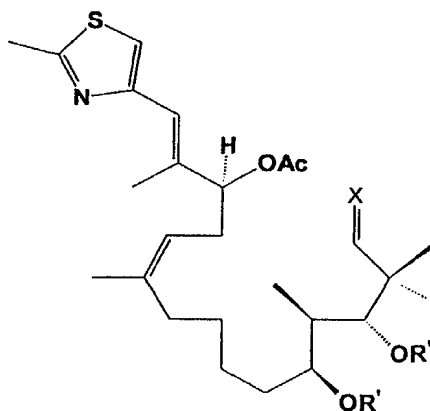
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-27-



- wherein R' and R'' are independently hydrogen, a linear or branched alkyl, substituted or unsubstituted aryl or benzyl, trialkylsilyl, dialkylarylsilyl, alkyldiarylsilyl, a linear or branched acyl, substituted or unsubstituted aroyl or benzoyl; wherein X is oxygen, $(OR^*)_2$, $(SR^*)_2$, $-(O-(CH_2)_n-O)-$, $-(O-(CH_2)_n-S)-$ or $-(S-(CH_2)_n-S)-$; wherein R^* is a linear or branched alkyl, substituted or unsubstituted aryl or benzyl; wherein R_2B is a linear, branched or cyclic boranyl moiety; and wherein n is 2, 3 or 4. In certain embodiments, the invention provides the compound wherein R' is TBS, R'' is TPS and X is $(OMe)_2$. A preferred example of R_2B is derived from 9-BBN.

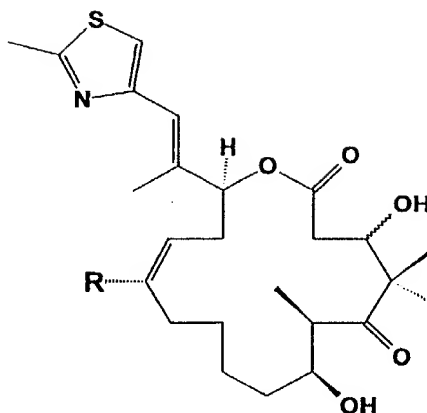
The invention also provides the compound having the structure:



- wherein R' and R'' are independently hydrogen, a linear or branched alkyl, substituted or unsubstituted aryl or benzyl, trialkylsilyl, dialkylarylsilyl, alkyldiarylsilyl, a linear or branched acyl, substituted or unsubstituted aroyl or benzoyl; wherein X is oxygen, $(OR)_2$, $(SR)_2$, $-(O-(CH_2)_n-O)-$, $-(O-(CH_2)_n-S)-$ or $-(S-(CH_2)_n-S)-$; and wherein n is 2, 3 or 4. In certain embodiments, the invention provides the compound wherein R' is TBS, R'' is TPS and X is $(OMe)_2$.

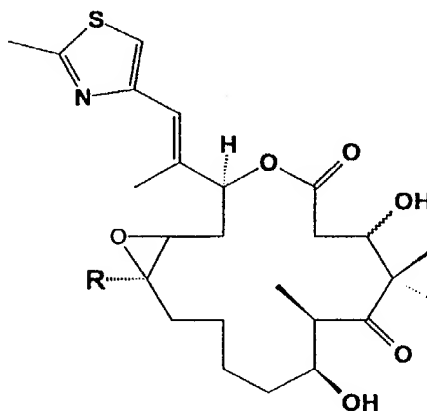
The invention further provides a desmethylepothilone analogue having the structure:

-28-



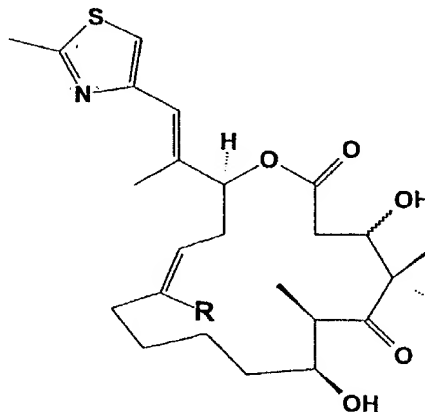
wherein R is H or methyl.

5 The invention provides a compound having the structure:



wherein R is H or methyl.

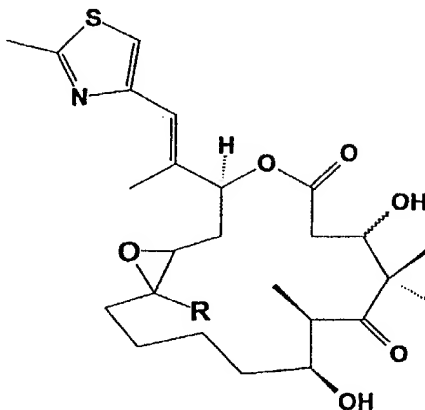
10 The invention also provides a trans-desmethyleoxyepothilone analogue having the structure:



-29-

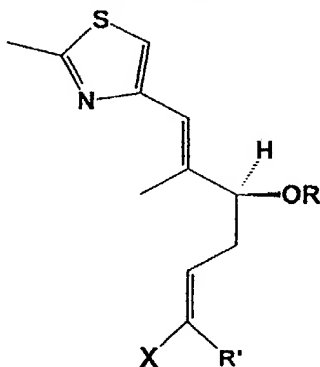
wherein R is H or methyl.

The invention also provides a trans-epothilone having the structure:

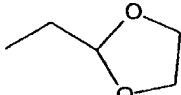


5 wherein R is H or methyl.

The invention also provides a compound having the structure:



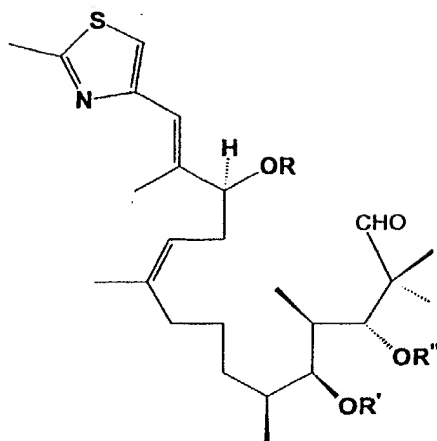
10 wherein R is hydrogen, a linear or branched alkyl, alkoxyalkyl, substituted or unsubstituted aryloxyalkyl, linear or branched acyl, substituted or unsubstituted aroyl or benzoyl; wherein

R' is hydrogen, methyl, ethyl, n-propyl, n-hexyl, , CO₂Et or (CH₂)₃OTBDPS.

and X is a halogen. In certain embodiments, the invention provides the compound wherein R is acetyl and X is iodine.

15 The invention additionally provides a method of preparing an open-chain aldehyde having the structure:

-30-

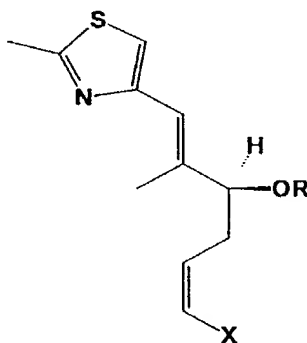


wherein R is a linear or branched alkyl, alkoxyalkyl, substituted or unsubstituted aryloxyalkyl, trialkylsilyl, aryldialkylsilyl, diarylalkylsilyl, triarylsilyl, linear or branched acyl, substituted or unsubstituted aroyl or benzoyl; and wherein R' and R'' are independently hydrogen, a

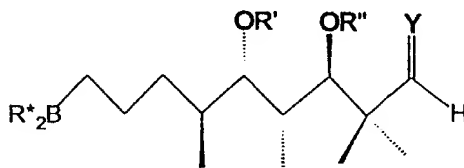
5 or unsubstituted aroyl or benzoyl; and wherein R' and R'' are independently hydrogen, a linear or branched alkyl, substituted or unsubstituted aryl or benzyl, trialkylsilyl, dialkylarylsilyl, alkylarylsilyl, a linear or branched acyl, substituted or unsubstituted aroyl or benzoyl, which comprises:

(a) cross-coupling a haloolefin having the structure:

10



wherein X is a halogen, with a terminal borane having the structure:

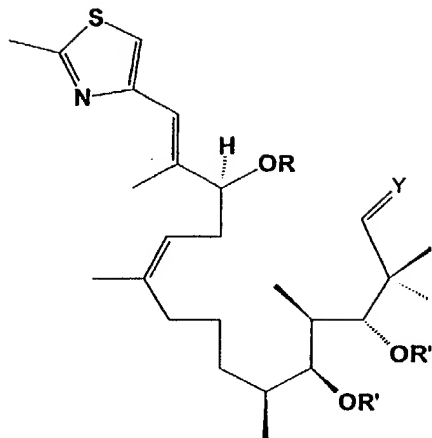


15

wherein R_2B is a linear, branched or cyclic alkyl or substituted or unsubstituted aryl or benzyl boranyl moiety; and wherein Y is $(OR_0)_2$, $(SR_0)_2$, $-(O-(CH_2)_n-O)-$, $-(O-(CH_2)_n-S)-$ or $-(S-(CH_2)_n-S)-$ where R_0 is a linear or branched alkyl, substituted or unsubstituted aryl or benzyl; and wherein n is 2, 3 or 4, under suitable conditions to form a cross-coupled compound having the

-31-

structure:



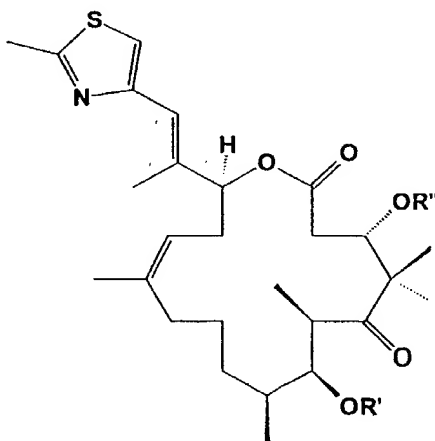
5

and

(b) deprotecting the cross-coupled compound formed in step (a) under suitable conditions to form the open-chain aldehyde. In certain embodiments, the invention provides the method wherein R is acetyl; R' is TBS; R'' is TPS; R*,B is derived from 9-BBN; and Y is (OMe)₂.

- 10 Cross-coupling step (a) is effected using reagents known in the art which are suited to the purpose. For example, the mixed borane may be cross-coupled with an organometallic catalyst such as PdCl₂(dppf)₂, or any known equivalent thereof, in the presence of such reagents as cesium carbonate and triphenylarsine. Deprotecting step (b) can be carried out
- 15 using a mild acid catalyst such as p-tosic acid, typically in a mixed aqueous organic solvent system, such as dioxane-water.

The invention also provides a method of preparing a protected epothilone having the structure:



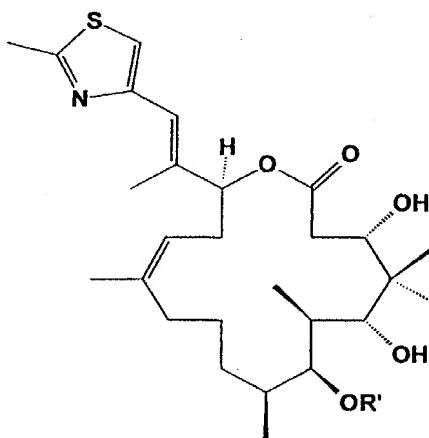
- 20 wherein R' and R'' are independently hydrogen, a linear or branched alkyl, substituted or

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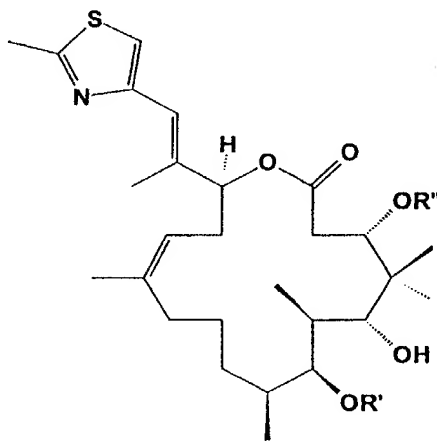
unsubstituted aryl or benzyl, trialkylsilyl, dialkyl-arylsilyl, alkyldiarylsilyl, a linear or branched acyl, substituted or unsubstituted aroyl or benzoyl, which comprises:

(a) monoprotecting a cyclic diol having the structure:

5



under suitable conditions to form a cyclic alcohol having the structure:



10

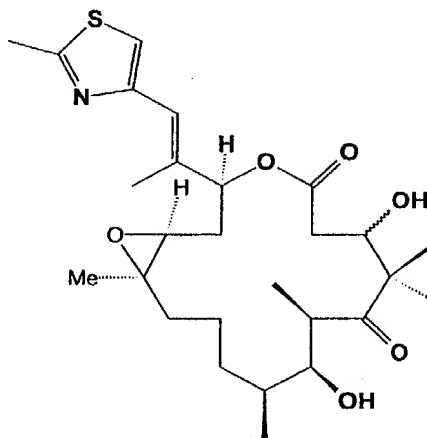
and

(b) oxidizing the cyclic alcohol formed in step (a) under suitable conditions to form the protected epothilone. In certain embodiments, the invention provides the method wherein R' and R'' are TBS. The monoprotecting step (a) may be effected using any of a variety of suitable reagents, including TBSOTf in the presence of a base in an inert organic solvent. The base may be a non-nucleophilic base such as 2,6-lutidine, and the solvent may be dichloromethane. The reaction is conducted at subambient temperatures, preferably in the range of -30°C. The oxidizing step (b) utilizes a selective oxidant such as Dess-Martin periodinane in an inert organic solvent such as dichloromethane. The oxidation is carried out at ambient temperatures, preferably at 20-25°C.

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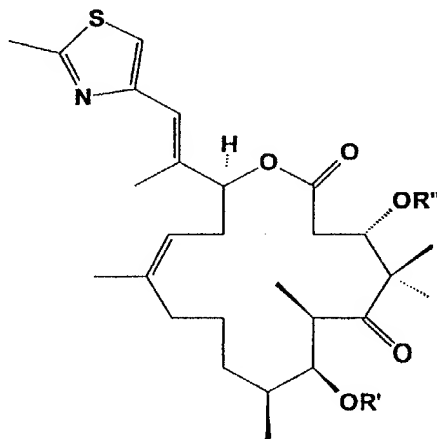
The invention further provides a method of preparing an epothilone having the structure:



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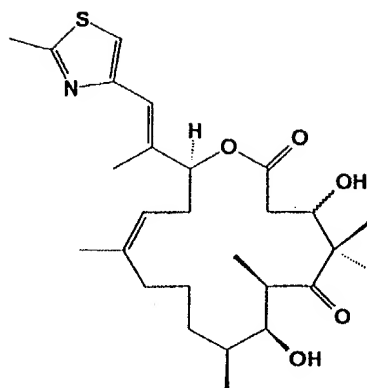
which comprises:

(a) deprotecting a protected cyclic ketone having the structure:



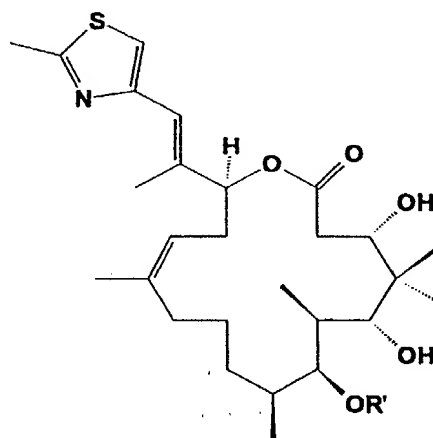
10 wherein R' and R'' are independently hydrogen, a linear or branched alkyl, substituted or unsubstituted aryl or benzyl, trialkylsilyl, dialkylarylsilyl, alkyldiarylsilyl, a linear or branched acyl, substituted or unsubstituted aroyl or benzoyl, under suitable conditions to form a desoxyepothilone having the structure:

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and (b) epoxidizing the desoxyepothilone formed in step (a) under suitable conditions to form the epothilone. In certain embodiments, the invention provides the method wherein R' and R'' are TBS. Deprotecting step (a) is carried out by means of a treatment comprising a reagent such as HF-pyridine. The deprotected compound can be epoxidized in step (b) using an epoxidizing agent such as acetic peracid, hydrogen peroxide, perbenzoic acid, m-chloroperbenzoic acid, but preferably with dimethyldioxirane, in an inert organic solvent such as dichloromethane.

10 The invention also provides a method of preparing a cyclic diol having the structure:

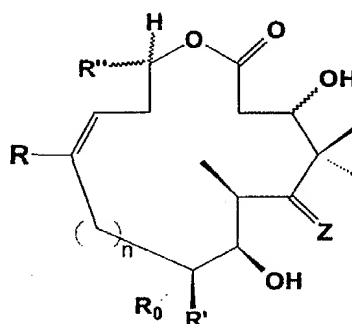


15 wherein R' is a hydrogen, a linear or branched alkyl, substituted or unsubstituted aryl or benzyl, trialkylsilyl, dialkylarylsilyl, alkyldiarylsilyl, a linear or branched acyl, substituted or unsubstituted aroyl or benzoyl, which comprises:

(a) cyclizing an open-chain aldehyde having the structure:

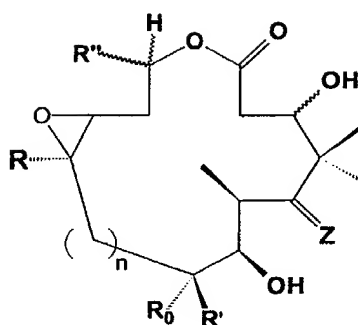
- THF. The reaction is carried out at subambient temperatures, preferably between -90°C and -50°C, more preferably at -78°C. Isolation of the unnatural alpha-OH diastereomer is effected by any usual purification method, including any suitable type of chromatography or by crystallization. Chromatographic techniques useful for the purpose include high pressure
- 5 liquid chromatography, countercurrent chromatography or flash chromatography. Various column media are suited, including, *inter alia*, silica or reverse phase support. The beta-OH derivative is then oxidized using a selective oxidant, such as Dess-Martin periodinane. The resulting ketone is the reduced using a selective reductant. Various hydridoborane and aluminum hydride reagents are effective. A preferred reducing agent is sodium borohydride.
- 10 Treating step (c) may be effected using a variety of deprotecting agents, including HF-pyridine.

The present invention provides a method of preparing a desoxyepothilone having the structure:

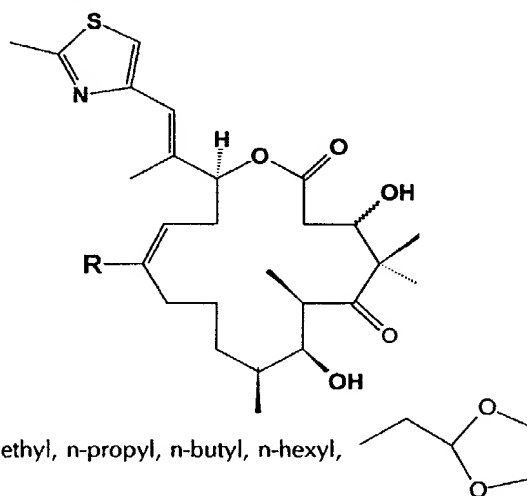


- 15 wherein R, R₀, and R' are independently H, linear or branched chain alkyl, optionally substituted by hydroxy, alkoxy, carboxy, carboxaldehyde, linear or branched alkyl or cyclic acetal, fluorine, NR₁R₂, N-hydroximino, or N-alkoxyimino, wherein R₁ and R₂ are independently H, phenyl, benzyl, linear or branched chain alkyl; wherein R'' is -CY=CX-, or
- 20 H, linear or branched chain alkyl, phenyl, 2-methyl-1,3-thiazoliny, 2-furanyl, 3-furanyl, 4-furanyl, 2-pyridyl, 3-pyridyl, 4-pyridyl, imidazolyl, 2-methyl-1,3-oxazoliny, 3-indolyl or 6-indolyl; wherein X is H, linear or branched chain alkyl, phenyl, 2-methyl-1,3-thiazoliny, 2-furanyl, 3-furanyl, 4-furanyl, 2-pyridyl, 3-pyridyl, 4-pyridyl, imidazolyl, 2-methyl-1,3-oxazoliny, 3-indolyl or 6-indolyl; wherein Y is H or linear or branched chain alkyl; wherein
- 25 Z is O, N(OR₃) or N-NR₄R₅, wherein R₃, R₄ and R₅ are independently H or a linear or branched alkyl; and wherein n is 0, 1, 2, or 3; which comprises treating an epothilone having a structure:

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wherein R , R_0 , R_1 , R_2 , R_3 , R_4 , R_5 , R' , R'' , X , Y , Z and n are defined as for the
 5 desoxyepothilone, under suitable conditions so as to deoxygenate the epothilone, and thereby
 to provide the desoxyepothilone. In one embodiment, the method is effected wherein the
 desoxyepothilone has the structure:

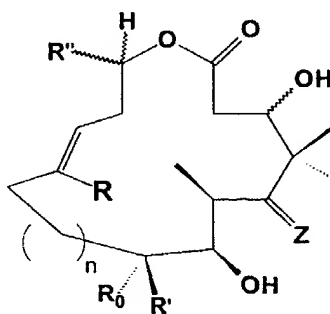


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wherein R is H, methyl, ethyl, n-propyl, n-butyl, n-hexyl,  or $(CH_2)_3-OH$.

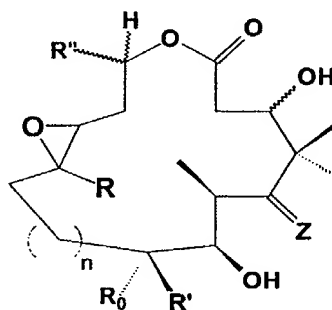
In another embodiment, the method is effected wherein the epothilone is deoxygenated using
 a zinc/copper couple. Preferably, the method is carried out wherein the epothilone is
 deoxygenated in the presence of a polar solvent comprising isopropanol and water.

15 The present invention further provides a method of preparing a desoxyepothilone
 having the structure:

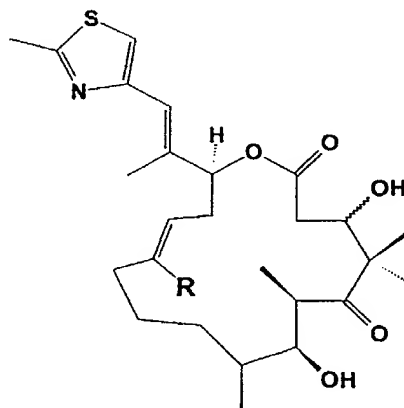


-38-

wherein R , R_0 , and R' are independently H, linear or branched chain alkyl, optionally substituted by hydroxy, alkoxy, carboxy, carboxaldehyde, linear or branched alkyl or cyclic acetal, fluorine, NR_1R_2 , N-hydroxyimino, or N-alkoxyimino, wherein R_1 and R_2 are independently H, phenyl, benzyl, linear or branched chain alkyl; wherein R'' is -CY=CHX, or H, linear or branched chain alkyl, phenyl, 2-methyl-1,3-thiazolyl, 2-furanyl, 3-furanyl, 4-furanyl, 2-pyridyl, 3-pyridyl, 4-pyridyl, imidazolyl, 2-methyl-1,3-oxazolyl, 3-indolyl or 6-indolyl; wherein X is H, linear or branched chain alkyl, phenyl, 2-methyl-1,3-thiazolyl, 2-furanyl, 3-furanyl, 4-furanyl, 2-pyridyl, 3-pyridyl, 4-pyridyl, imidazolyl, 2-methyl-1,3-oxazolyl, 3-indolyl or 6-indolyl; wherein Y is H or linear or branched chain alkyl; wherein Z is O, $N(OR_3)$ or $N-NR_4R_5$, wherein R_3 , R_4 and R_5 are independently H or a linear or branched chain alkyl; and wherein n is 0, 1, 2, or 3; which comprises treating an epothilone having a structure:



wherein R , R_0 , R_1 , R_2 , R_3 , R_4 , R_5 , R' , R'' , X, Y, Z and n are defined as for the desoxyepothilone, under suitable conditions so as to deoxygenate the epothilone, and thereby to provide the desoxyepothilone. In one embodiment, the method is performed wherein the desoxyepothilone has the structure:



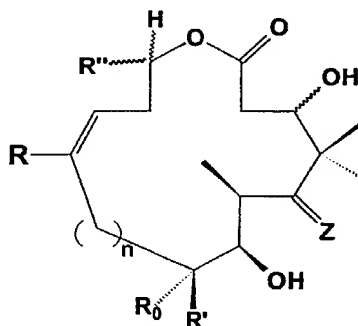
wherein R is H, methyl, ethyl, n-propyl, n-butyl, n-hexyl or hydroxypropyl. Preferably, the method is effected wherein the epothilone is deoxygenated using a zinc/copper couple.

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Favorably, the epothilone is deoxygenated in the presence of a polar solvent comprising isopropanol and water.

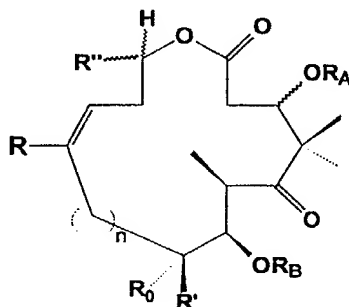
The present invention also provides a method of preparing a desoxyepothilone having the structure:

5



wherein R, R₀, and R' are independently H, linear or branched chain alkyl, optionally substituted by hydroxy, alkoxy, carboxy, carboxaldehyde, linear or branched alkyl or cyclic acetal, fluorine, NR₁R₂, N-hydroximino, or N-alkoxyimino, wherein R₁ and R₂ are independently H, phenyl, benzyl, linear or branched chain alkyl; wherein R'' is -CY=CHX, or H, linear or branched chain alkyl, phenyl, 2-methyl-1,3-thiazolyl, 2-furanyl, 3-furanyl, 4-furanyl, 2-pyridyl, 3-pyridyl, 4-pyridyl, imidazolyl, 2-methyl-1,3-oxazolyl, 3-indolyl or 6-indolyl; wherein X is H, linear or branched chain alkyl, phenyl, 2-methyl-1,3-thiazolyl, 2-furanyl, 3-furanyl, 4-furanyl, 2-pyridyl, 3-pyridyl, 4-pyridyl, imidazolyl, 2-methyl-1,3-oxazolyl, 3-indolyl or 6-indolyl; wherein Y is H or linear or branched chain alkyl; and wherein Z is O, N(OR₃) or N-NR₄R₅ where R₃, R₄ and R₅ are independently H or a linear or branched alkyl; and wherein n is 0, 1, 2, or 3; which comprises treating a protected desoxyepothilone having the structure:

20



wherein R_A is a linear or branched alkyl, alkoxyalkyl, substituted or unsubstituted aryloxyalkyl, trialkylsilyl, aryldialkylsilyl, diarylalkylsilyl, triarylsilyl, linear or branched acyl, substituted or unsubstituted aroyl or benzoyl; and wherein R_B is hydrogen, t-butyloxycarbonyl, amyloxycarbonyl, (trialkylsilyl)alkyloxycarbonyl, (dialkylarylsilyl) alkyloxycarbonyl, benzyl, trialkylsilyl, dialkylarylsilyl, alkylarylsilyl, triarylsilyl, a linear or branched acyl, substituted

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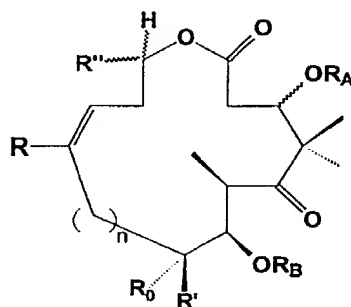
-40-

or unsubstituted aroyl or benzoyl; under suitable conditions to form the desoxyepothilone. In a certain embodiment, the invention provides a method wherein n is 3 and R'' is 2-methyl-1,3-thiazolinyl. Preferably, the method is effected wherein R_A is TES and R_B is Troc. In a certain other embodiment, the invention provides a method wherein the treating step

5 comprises contacting the protected desoxyepothilone (i) with SmX_2 , where X is Cl, Br or I, in the presence of a polar nonaqueous solvent selected from the group consisting of tetrahydrofuran, p-dioxane, diethyl ether, acetonitrile and N,N-dimethylformamide, and optionally in the presence of N,N-dimethyl-N'-propylurea or hexamethylphosphoramide and

10 (ii) with a source of fluoride ion selected from the group consisting of tetra-n-methylammonium fluoride, tetra-n-butylammonium fluoride and HF-pyridine.

The present invention also provides a method of preparing a protected desoxyepothilone having the structure:



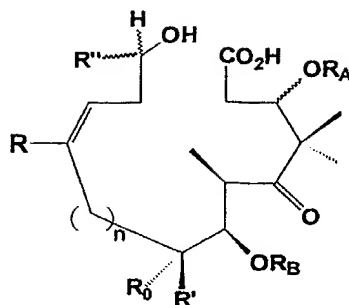
15 wherein R , R_0 , and R' are independently H, linear or branched chain alkyl, optionally substituted by hydroxy, alkoxy, carboxy, carboxaldehyde, linear or branched alkyl or cyclic acetal, fluorine, NR_1R_2 , N-hydroximino, or N-alkoxyimino, wherein R_1 and R_2 are independently H, phenyl, benzyl, linear or branched chain alkyl; wherein R'' is -CY=CHX,

20 or H, linear or branched chain alkyl, phenyl, 2-methyl-1,3-thiazolinyl, 2-furanyl, 3-furanyl, 4-furanyl, 2-pyridyl, 3-pyridyl, 4-pyridyl, imidazolyl, 2-methyl-1,3-oxazolinyl, 3-indolyl or 6-indolyl; wherein X is H, linear or branched chain alkyl, phenyl, 2-methyl-1,3-thiazolinyl, 2-furanyl, 3-furanyl, 4-furanyl, 2-pyridyl, 3-pyridyl, 4-pyridyl, imidazolyl, 2-methyl-1,3-oxazolinyl, 3-indolyl or 6-indolyl; wherein Y is H or linear or branched chain alkyl; wherein

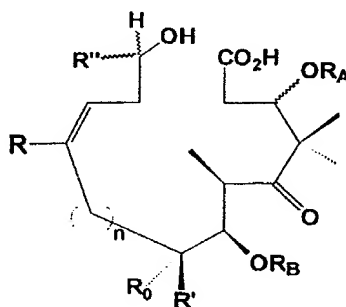
25 n is 2 or 3; wherein R_A is a linear or branched alkyl, alkoxyalkyl, substituted or unsubstituted aryloxyalkyl, trialkylsilyl, aryldialkylsilyl, diarylalkylsilyl, triarylsilyl, linear or branched acyl, substituted or unsubstituted aroyl or benzoyl; and wherein R_B is hydrogen, t-butyloxycarbonyl, amyloxycarbonyl, (trialkylsilyl)alkyloxycarbonyl, (dialkylarylsilyl)alkyloxycarbonyl, benzyl, trialkylsilyl, dialkylarylsilyl, alkylarylsilyl, triarylsilyl, a linear or branched acyl, substituted

30 or unsubstituted aroyl or benzoyl; which comprises cyclocondensing a hydroxy acid desoxyepothilone precursor having the structure:

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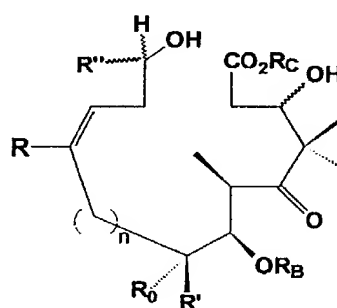
- wherein R, R₀, R_A, R_B, R', R'' and n are defined as above; under suitable conditions to form the protected desoxyepothilone. In particular, the method is carried out wherein n is 3 and R'' is 2-methyl-1,3-thiazolinyl. Preferably, R_A is a trialkylsilyl, and is more preferably, TES. R_B is favorably trichloroethoxycarbonyl (Troc). According to the method, the hydroxy acid desoxyepothilone precursor is cyclocondensed using a cyclocondensing reagent selected from the group consisting of acetic anhydride, pentafluorophenol, 2,4-dichlorobenzoyl chloride and, preferably, 2,4,6-trichlorobenzoyl chloride. In addition, the hydroxyacid is favorably cyclocondensed using 2,4,6-trichlorobenzoyl chloride in the presence of a tertiary amine selected from the group consisting of triethyl amine, tri-n-propylamine, diisopropylethylamine and diethyliso-propylamine, and optionally in the presence of pyridine or N,N-dimethylaminopyridine.
- The present invention further provides a method of preparing a hydroxy acid desoxyepothilone precursor having the structure:



- wherein R, R₀, and R' are independently H, linear or branched chain alkyl, optionally substituted by hydroxy, alkoxy, carboxy, carboxaldehyde, linear or branched alkyl or cyclic acetal, fluorine, NR₁R₂, N-hydroximino, or N-alkoxyimino, wherein R₁ and R₂ are independently H, phenyl, benzyl, linear or branched chain alkyl; wherein R'' is -CY=CHX, or H, linear or branched chain alkyl, phenyl, 2-methyl-1,3-thiazolinyl, 2-furanyl, 3-furanyl, 4-furanyl, 2-pyridyl, 3-pyridyl, 4-pyridyl, imidazolyl, 2-methyl-1,3-oxazolinyl, 3-indolyl or 6-indolyl; wherein X is H, linear or branched chain alkyl, phenyl, 2-methyl-1,3-thiazolinyl, 2-furanyl, 3-furanyl, 4-furanyl, 2-pyridyl, 3-pyridyl, 4-pyridyl, imidazolyl, 2-methyl-1,3-

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oxazoliny, 3-indoly or 6-indoly; wherein Y is H or linear or branched chain alkyl; wherein n is 2 or 3; wherein R_A is a linear or branched alkyl, alkoxyalkyl, substituted or unsubstituted aryloxyalkyl, trialkylsilyl, aryldialkylsilyl, diarylalkylsilyl, triarylsilyl, linear or branched acyl, substituted or unsubstituted aroyl or benzoyl; wherein R_B is hydrogen, t-butyloxycarbonyl, amyloxycarbonyl, (trialkylsilyl) alkyloxycarbonyl, (dialkylarylsilyl) alkyloxycarbonyl, benzyl, trialkylsilyl, dialkylarylsilyl, alkyldiarylsilyl, triarylsilyl, linear or branched acyl, substituted or unsubstituted aroyl or benzoyl; which comprises selectively etherifying and hydrolyzing a hydroxy ester desoxyepothilone precursor having the structure:



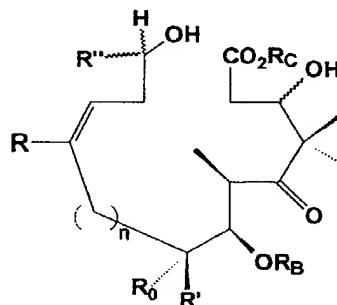
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wherein R, R_0 , R_B , R_C , R' , R'' and n are defined as above; and wherein R_C is tertiary-alkyl; under suitable conditions to form the hydroxy acid desoxyepothilone precursor. In one embodiment, the invention is practiced wherein n is 3 and R'' is 2-methyl-1,3-thiazoliny. Preferably, R_A is TES and R_B is Troc. In accord with invention, the method is performed wherein the selective etherifying step comprises contacting the hydroxy ester desoxyepothilone precursor with a silylating reagent to form an ether intermediate, and the hydrolyzing step comprises contacting the ether intermediate with a protic acid or tetra-n-butylammonium fluoride. Favorably, the silylating reagent is TESOTf in the presence of 2,6-lutidine. The protic acid is typically HCl in the presence of an alkyl alcohol, preferably, methyl alcohol or ethyl alcohol.

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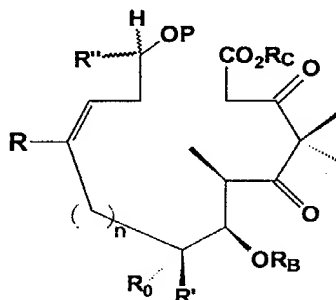
The present invention also provides a method of preparing a hydroxy ester desoxyepothilone precursor having the structure:

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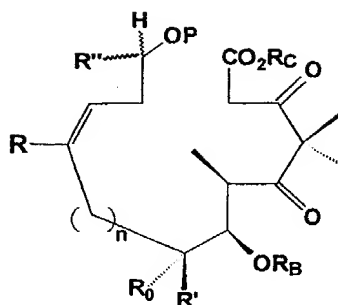
wherein R, R₀, and R' are independently H, linear or branched chain alkyl, optionally substituted by hydroxy, alkoxy, carboxy, carboxaldehyde, linear or branched alkyl or cyclic acetal, fluorine, NR₁R₂, N-hydroximino, or N-alkoxyimino, wherein R₁ and R₂ are independently H, phenyl, benzyl, linear or branched chain alkyl; wherein R'' is -CY=CHX, or H, linear or branched chain alkyl, phenyl, 2-methyl-1,3-thiazoliny, 2-furanyl, 3-furanyl, 4-furanyl, 2-pyridyl, 3-pyridyl, 4-pyridyl, imidazolyl, 2-methyl-1,3-oxazoliny, 3-indolyl or 6-indolyl; wherein X is H, linear or branched chain alkyl, phenyl, 2-methyl-1,3-thiazoliny, 2-furanyl, 3-furanyl, 4-furanyl, 2-pyridyl, 3-pyridyl, 4-pyridyl, imidazolyl, 2-methyl-1,3-oxazoliny, 3-indolyl or 6-indolyl; wherein Y is H or linear or branched chain alkyl; wherein n is 2 or 3; wherein R_B is hydrogen, t-butyloxycarbonyl, amyloxycarbonyl, (trialkylsilyl)alkyloxycarbonyl, (dialkylarylsilyl)alkyloxycarbonyl, benzyl, trialkylsilyl, dialkylarylsilyl, alkyldiarylsilyl, triarylsilyl, linear or branched acyl, substituted or unsubstituted aroyl or benzoyl; and wherein R_C is tertiary-alkyl; which comprises reducing a hydroxy ketoester desoxyepothilone precursor having the structure:



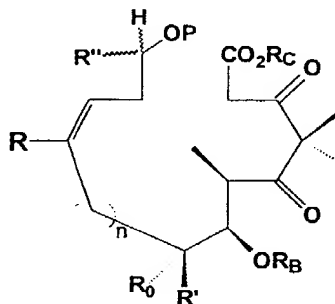
wherein P, R, R₀, R_B, R_C, R', R'' and n are defined as above; under suitable conditions to form the hydroxy ester desoxyepothilone precursor. In one embodiment, the invention provides the method wherein n is 3 and R'' is 2-methyl-1,3-thiazoliny. In particular, R_A is a trialkylsilyl group, and is, preferably, TES. R_B is Troc. In accord with the invention, the reducing step comprises contacting the hydroxy ketoester desoxyepothilone precursor with a stereospecific reducing reagent. The stereospecific reducing reagent favorably comprises hydrogen gas at from about 900 pounds per square inch to about 2200 pounds per square inch in the presence of (R)-(BINAP)RuCl₂ and optionally in the presence of HCl and an alcohol selected from the group consisting of MeOH, EtOH, and i-PrOH. More preferably, the hydrogen gas pressure is 1200 psi.

The present invention further provides a method of preparing a hydroxy ketoester desoxyepothilone precursor having the structure:

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wherein P is H; wherein R, R₀, and R' are independently H, linear or branched chain alkyl,
 5 optionally substituted by hydroxy, alkoxy, carboxy, carboxaldehyde, linear or branched alkyl
 or cyclic acetal, fluorine, NR₁R₂, N-hydroximino, or N-alkoxyimino, wherein R₁ and R₂ are
 independently H, phenyl, benzyl, linear or branched chain alkyl; wherein R'' is -CY=CHX,
 or H, linear or branched chain alkyl, phenyl, 2-methyl-1,3-thiazolynyl, 2-furanyl, 3-furanyl, 4-
 furanyl, 2-pyridyl, 3-pyridyl, 4-pyridyl, imidazolyl, 2-methyl-1,3-oxazolynyl, 3-indolyl or 6-
 10 indolyl; wherein X is H, linear or branched chain alkyl, phenyl, 2-methyl-1,3-thiazolynyl, 2-
 furanyl, 3-furanyl, 4-furanyl, 2-pyridyl, 3-pyridyl, 4-pyridyl, imidazolyl, 2-methyl-1,3-
 oxazolynyl, 3-indolyl or 6-indolyl; wherein Y is H or linear or branched chain alkyl; wherein
 n is 2 or 3; wherein R_B is hydrogen, t-butyloxycarbonyl, amyloxycarbonyl,
 (trialkylsilyl)alkyloxycarbonyl, (dialkylarylsilyl)alkyloxycarbonyl, benzyl, trialkylsilyl,
 15 dialkylarylsilyl, alkyldiarylsilyl, triarylsilyl, a linear or branched acyl, substituted or
 unsubstituted aroyl or benzoyl; and wherein R_c is tertiary-alkyl; which comprises deprotecting
 a protected ketoester desoxyepothilone precursor having the structure:



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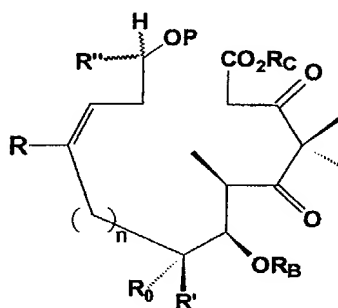
wherein R, R₀, R_A, R_B, R_C, R', R'' and n are defined as above; and wherein P is a linear or
 branched alkyl, alkoxyalkyl, substituted or unsubstituted aryloxyalkyl, trialkylsilyl,
 aryltrialkylsilyl, diaryltrialkylsilyl or triarylsilyl; under suitable conditions to form the hydroxy
 25 ketoester desoxyepothilone precursor. In one embodiment, n is 3 and R'' is 2-methyl-1,3-
 thiazolynyl. R_A is typically trialkylsilyl, and, preferably, is TES. R_B is favorably Troc. The
 method is effectively practiced wherein P is TBS. In accord with the invention, the

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deprotecting step comprises contacting the protected ketoester desoxyepothilone precursor with a protic acid. Preferably, the protic acid is HCl in methyl alcohol or ethyl alcohol.

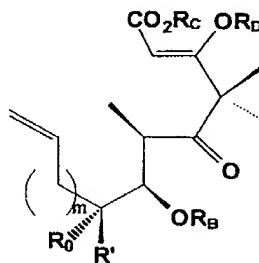
The present invention also provides a method of preparing a protected ketoester desoxyepothilone precursor having the structure:

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- wherein P is a linear or branched alkyl, alkoxyalkyl, substituted or unsubstituted aryloxyalkyl, trialkylsilyl, aryldialkylsilyl, diarylalkylsilyl or triarylsilyl; wherein R, R₀, and R' are independently H, linear or branched chain alkyl, optionally substituted by hydroxy, alkoxy, carboxy, carboxaldehyde, linear or branched alkyl or cyclic acetal, fluorine, NR₁R₂, N-hydroxyimino, or N-alkoxyimino, wherein R₁ and R₂ are independently H, phenyl, benzyl, linear or branched chain alkyl; wherein R'' is -CY=CHX, or H, linear or branched chain alkyl, phenyl, 2-methyl-1,3-thiazolynyl, 2-furanyl, 3-furanyl, 4-furanyl, 2-pyridyl, 3-pyridyl, 4-pyridyl, imidazolyl, 2-methyl-1,3-oxazolynyl, 3-indolyl or 6-indolyl; wherein X is H, linear or branched chain alkyl, phenyl, 2-methyl-1,3-thiazolynyl, 2-furanyl, 3-furanyl, 4-furanyl, 2-pyridyl, 3-pyridyl, 4-pyridyl, imidazolyl, 2-methyl-1,3-oxazolynyl, 3-indolyl or 6-indolyl; wherein Y is H or linear or branched chain alkyl; wherein n is 2 or 3; wherein R_B is hydrogen, t-butyloxycarbonyl, amyloxycarbonyl, (trialkylsilyl)alkyl-oxycarbonyl, (dialkylarylsilyl)alkyloxycarbonyl, benzyl, trialkylsilyl, dialkylarylsilyl, alkyldiarylsilyl, triarylsilyl, a linear or branched acyl, substituted or unsubstituted aroyl or benzoyl; and wherein R_C is tertiary-alkyl; which comprises coupling a terminal vinyl enol ether ester having the structure:

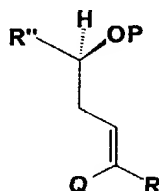
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wherein R, R₀, R_B, R_C, and R' are defined as above; wherein m is 0, 1 or 2; and wherein R_D is linear or branched alkyl, benzyl, trialkylsilyl, dialkylarylsilyl, alkyldiarylsilyl, linear or branched acyl, substituted or unsubstituted aroyl or benzoyl; with a protected halovinyl or metalvinyl compound having the structure:

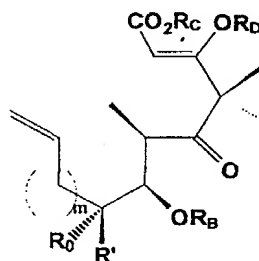
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wherein R, P and R'' are defined as above; and wherein Q is a halide or a metal; under suitable conditions to form the protected ketoester desoxyepothilone precursor. In one embodiment, the invention provides the method wherein n is 3 and R'' is 2-methyl-1,3-thiazoliny. In another embodiment, the method is effectively performed wherein R_A is a trialkylsilyl group, and is, preferably, TES, and R_B is Troc. P is favorably TBS or TES, and Q is iodine or bromine. R_D is typically methyl or TES. In accord with the invention, the coupling step comprises contacting the terminal vinyl enol ether ester and the protected halovinyl compound with noble metal complex capable of effecting a Suzuki coupling. For this step, the noble metal complex is effectively chosen as Pd(dppf)₂Cl₂ in the presence of Ph₃As and Cs₂CO₃.

The present invention also provides a method of preparing a terminal vinyl enol ether ester having the structure:

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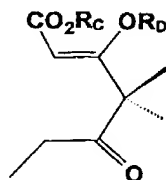


wherein R₀ and R' are independently H, linear or branched chain alkyl, optionally substituted by hydroxy, alkoxy, carboxy, carboxaldehyde, linear or branched alkyl or cyclic acetal, fluorine, NR₁R₂, N-hydroximino, or N-alkoxyimino, wherein R₁ and R₂ are independently H, phenyl, benzyl, linear or branched chain alkyl; wherein m is 0, 1 or 2; wherein R_B is hydrogen, t-butyloxycarbonyl, amyloxycarbonyl, (trialkylsilyl)alkyl-oxycarbonyl, (dialkylarylsilyl)alkyl-oxycarbonyl, benzyl, trialkylsilyl, dialkylarylsilyl, alkyldiarylsilyl, triarylsilyl, linear or branched acyl, substituted or unsubstituted aroyl or benzoyl; wherein R_C is tertiary-alkyl; and wherein R_D is linear or branched alkyl, benzyl, trialkylsilyl,

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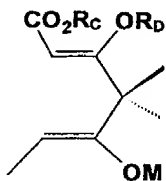
dialkylarylsilyl, alkyl diarylsilyl, triarylsilyl, linear or branched acyl, substituted or unsubstituted aroyl or benzoyl; which comprises:

(a) treating a keto enol ester having the structure:



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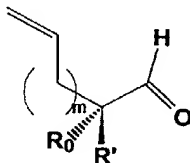
under suitable conditions to form an enolate enol ester having the structure:



wherein M is Li, Na or K; and

10

(b) coupling the enolate enol ester with a vinyl aldehyde having the structure:



wherein m, and R_0 and R' are as defined above; under suitable conditions to form the terminal vinyl enol ether ester. In accord with the invention, the treating step comprises contacting the keto enol ester with a strong nonnucleophilic base selected from the group consisting of lithium diethylamide, lithium diisopropylamide, lithium hydride, sodium hydride, potassium hydride and potassium t-butoxide. Preferably, the treating step is effected in a polar nonaqueous solvent selected from the group consisting of tetrahydrofuran, diethyl ether, di-n-propyl ether and dimethylformamide at a temperature from about -100°C to about $+10^{\circ}\text{C}$. More preferably, the temperature is from about -20°C to -40°C . The coupling step as practiced in the invention comprises contacting the enolate enol ester with the vinyl aldehyde at a temperature from about -130°C to about -78°C .

In addition, the invention provides a method of treating cancer in a subject suffering therefrom comprising administering to the subject a therapeutically effective amount of any of the analogues related to epothilone B disclosed herein optionally in combination with an additional chemotherapeutic agent and/or with a pharmaceutically suitable carrier. The method may be applied where the cancer is a solid tumor or leukemia. In particular, the method is applicable where the cancer is breast cancer or melanoma.

The subject invention also provides a pharmaceutical composition for treating cancer comprising any of the analogues of epothilone disclosed hereinabove, as an active ingredient, optionally though typically in combination with an additional chemotherapeutic agent and/or a pharmaceutically suitable carrier. The pharmaceutical compositions of the present invention
5 may further comprise other therapeutically active ingredients.

The subject invention further provides a method of treating cancer in a subject suffering therefrom comprising administering to the subject a therapeutically effective amount of any of the analogues of epothilone disclosed hereinabove and a pharmaceutically suitable carrier. The method is especially useful where the cancer is a solid tumor or leukemia.

10 The compounds taught above which are related to epothilones A and B are useful in the treatment of cancer, and particularly, in cases where multidrug resistance is present, both *in vivo* and *in vitro*. The ability of these compounds as non-substrates of MDR in cells, as demonstrated in the Tables below, shows that the compounds are useful to treat, prevent or ameliorate cancer in subjects suffering therefrom.

15 The magnitude of the therapeutic dose of the compounds of the invention will vary with the nature and severity of the condition to be treated and with the particular compound and its route of administration. In general, the daily dose range for anticancer activity lies in the range of 0.001 to 25 mg/kg of body weight in a mammal, preferably 0.001 to 10 mg/kg, and most preferably 0.001 to 1.0 mg/kg, in single or multiple doses. In unusual cases, it may
20 be necessary to administer doses above 25 mg/kg.

Any suitable route of administration may be employed for providing a mammal, especially a human, with an effective dosage of a compound disclosed herein. For example, oral, rectal, topical, parenteral, ocular, pulmonary, nasal, etc., routes may be employed. Dosage forms include tablets, troches, dispersions, suspensions, solutions, capsules, creams,
25 ointments, aerosols, etc.

The compositions include compositions suitable for oral, rectal, topical (including transdermal devices, aerosols, creams, ointments, lotions and dusting powders), parenteral (including subcutaneous, intramuscular and intravenous), ocular (ophthalmic), pulmonary (nasal or buccal inhalation) or nasal administration. Although the most suitable route in any
30 given case will depend largely on the nature and severity of the condition being treated and on the nature of the active ingredient. They may be conveniently presented in unit dosage form and prepared by any of the methods well known in the art of pharmacy.

In preparing oral dosage forms, any of the unusual pharmaceutical media may be used, such as water, glycols, oils, alcohols, flavoring agents, preservatives, coloring agents,
35 and the like in the case of oral liquid preparations (e.g., suspensions, elixers and solutions); or carriers such as starches, sugars, microcrystalline cellulose, diluents, granulating agents, lubricants, binders, disintegrating agents, etc., in the case of oral solid preparations are

preferred over liquid oral preparations such as powders, capsules and tablets. If desired, capsules may be coated by standard aqueous or non-aqueous techniques. In addition to the dosage forms described above, the compounds of the invention may be administered by controlled release means and devices.

5 Pharmaceutical compositions of the present invention suitable for oral administration may be prepared as discrete units such as capsules, cachets or tablets each containing a predetermined amount of the active ingredient in powder or granular form or as a solution or suspension in an aqueous or nonaqueous liquid or in an oil-in-water or water-in-oil emulsion. Such compositions may be prepared by any of the methods known in the art of pharmacy. In
10 general compositions are prepared by uniformly and intimately admixing the active ingredient with liquid carriers, finely divided solid carriers, or both and then, if necessary, shaping the product into the desired form. For example, a tablet may be prepared by compression or molding, optionally with one or more accessory ingredients. Compressed tablets may be prepared by compressing in a suitable machine the active ingredient in a free-flowing form
15 such as powder or granule optionally mixed with a binder, lubricant, inert diluent or surface active or dispersing agent. Molded tablets may be made by molding in a suitable machine, a mixture of the powdered compound moistened with an inert liquid diluent.

Methods of preparation of intermediates are disclosed in U.S. Patent Applications Serial Nos. 60/032,282, 60/033,767, 60/047,566, 60/047,941, and 60/055,533, filed December
20 3, 1996, January 14, 1997, May 22, 1997, May 29, 1997, and August 13, 1997, respectively, the contents of which are hereby incorporated by reference into this application.

The present invention will be better understood from the Experimental Details which follow. However, one skilled in the art will readily appreciate that the specific methods and results discussed are merely illustrative of the invention as described in the claims which
25 follow thereafter. It will be understood that the processes of the present invention for preparing epothilones A and B, analogues thereof and intermediates thereto encompass the use of various alternate protecting groups known in the art. Those protecting groups used in the disclosure including the Examples below are merely illustrative.

EXAMPLE 1

30 THP glycidol; 13: A solution of (R)-(+)-glycidol **12** (20 g; 270 mmol) and freshly distilled 3,4-dihydro-2H-pyran (68.1 g; 810 mmol) in CH₂Cl₂ (900 ml) was treated with pyridinium *p*-toluenesulfonate (2.1 g; 8.36 mmol) at rt and the resulting solution was stirred for 16 h. Approximately 50% of the solvent was then removed in vacuo and the remaining solution was diluted with ether (1 L). The organic layer was then washed with two portions of saturated
35 aqueous sodium bicarbonate (500 ml), dried (Na₂SO₄), filtered, and concentrated. Purification of the residue by flash chromatography (silica, 25 → 50% ether:hexanes) afforded THP glycidol **13** (31.2 g; 73%) as a colorless liquid: IR(film): 2941, 1122, 1034 cm⁻¹; ¹H

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NMR(CDCl₃, 500MHz) δ 4.66 (t, *J* = 3.5Hz, 1H), 4.64 (t, *J* = 3.5 Hz, 1H), 3.93 (dd, *J* = 11.7, 3.1Hz, 1H), 3.86 (m, 2H), 3.73 (dd, *J* = 11.8, 5.03 Hz, 1H), 3.67 (dd, *J* = 11.8, 3.4Hz, 1H), 3.51 (m, 2H), 3.40 (dd, *J* = 11.7, 6.4, 1H), 3.18 (m, 2H), 2.80 (m, 2H), 2.67 (dd, *J* = 5.2, 2.7 Hz, 1H), 2.58 (dd, *J* = 5.0, 2.7Hz, 1H), 1.82 (m, 2H), 1.73 (m, 2H), 1.52 (m, 4H); ¹³C NMR (CDCl₃, 125MHz) δ 98.9, 98.8, 68.5, 67.3, 62.4, 62.2, 50.9, 50.6, 44.6, 44.5, 30.5, 30.4, 25.4, 19.3, 19.2; [α]_D = +4.98 (c=2.15, CHCl₃).

EXAMPLE 2

Alcohol 13a: Trimethylsilylacetylene (32.3 g; 329 mmol) was added via syringe to THF (290 ml), and the resulting solution was cooled to -78 °C and treated with *n*-butyllithium (154 ml of a 1.6 M solution in hexanes; 246.4 mmol). After 15 min, boron trifluoride diethyl etherate (34.9 g; 246 mmol) was added, and the resulting mixture was stirred for 10 min. A solution of epoxide **13** (26 g; 164.3 mmol) in THF (130 ml) was then added via a cannula and the resulting solution was stirred for 5.5 h at -78 °C. The reaction was quenched by the addition of saturated aqueous sodium bicarbonate solution (250 ml) and the solution was allowed to warm to rt. The mixture was then diluted with ether (600 ml) and washed successively with saturated aqueous sodium bicarbonate solution (250 ml), water (250 ml), and brine (250 ml). The organic layer was then dried (Na₂SO₄), filtered, and concentrated in vacuo. Purification of the residue by flash chromatography (silica, 20% ether:hexanes) provided alcohol **13a** (34 g; 76%).

EXAMPLE 3

MOM ether 13b: A solution of alcohol **13a** (24 g; 88.9 mmol) and *N,N*-diisopropylethylamine (108 ml; 622 mmol) in anhydrous 1,2-dichloroethane (600 ml) was treated with chloromethyl methyl ether (17 ml; 196 mmol), and the resulting mixture was heated to 55 °C for 28 h. The dark mixture was then cooled to rt and treated with saturated aqueous sodium bicarbonate solution (300 ml). The layers were separated, and the organic layer was washed successively with saturated aqueous sodium bicarbonate solution (200 ml) and brine (200 ml). The organic layer was then dried (MgSO₄) and filtered through a pad of silica gel (ether rinse). Purification of the residue by flash chromatography (silica, 20 - 30% ether:hexanes) afforded MOM ether **13b** (23.7 g; 85%) as a pale yellow oil.

EXAMPLE 4

Alcohol 14: A solution of THP ether **13b** (20 g; 63.7 mmol) in methanol (90 ml) was treated with pyridinium *p*-toluenesulfonate (4.0 g; 15.9 mmol) and the resulting mixture was stirred at rt for 16 h. The reaction was then quenched by the addition of saturated aqueous sodium bicarbonate solution (100 ml), and the excess methanol was removed in vacuo. The residue was diluted with ether (300 ml), and the organic layer was washed successively with saturated aqueous sodium bicarbonate solution (200 ml) and brine (200 ml). The organic layer was

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dried (MgSO_4), filtered, and concentrated. Purification of the residue by flash chromatography (silica, 40 – 50% ether:hexanes) provided alcohol **14** (13.1 g; 95%) as a colorless oil.

EXAMPLE 5

Alcohol 14a: To a cooled (-78°C) solution of oxalyl chloride (24.04 ml of a 2.0 M solution in CH_2Cl_2 ; 48.08 mmol) in CH_2Cl_2 (165 ml) was added anhydrous DMSO (4.6 ml; 64.1 mmol) in dropwise fashion. After 30 min, a solution of alcohol **14** (6.93 g; 32.05 mmol) in CH_2Cl_2 (65 ml + 10 ml rinse) was added and the resulting solution was stirred at -78°C for 40 min. Freshly distilled triethylamine (13.4 ml; 96.15 mmol) was then added, the cooling bath was removed, and the mixture was allowed to warm to 0°C . The reaction mixture was then diluted with ether (500 ml), and washed successively with two portions of water (250 ml) and one portion of brine (250 ml). The organic layer was then dried (MgSO_4), filtered, and concentrated.

The crude aldehyde (6.9 g) prepared in the above reaction was dissolved in ether (160 ml) and cooled to 0°C . Methylmagnesium bromide (32.1 ml of a 3.0 M solution in butyl ether; 96.15 mmol) was then added, and the solution was allowed to warm slowly to rt. After 10 h, the reaction mixture was cooled to 0°C and the reaction was quenched by the addition of saturated aqueous ammonium chloride solution. The mixture was diluted with ether (200 ml) and washed successively with water (150 ml) and brine (150 ml). The organic layer was dried (MgSO_4), filtered, and concentrated. Purification of the residue by flash chromatography (silica, 40 – 50% ether:hexanes) provided alcohol **14a** (6.3 g; 85% from **14**).

EXAMPLE 6

Ketone 15: A solution of alcohol **14** (1.0 g; 4.35 mmol), 4 Å mol. sieves, and *N*-methylmorpholine-*N*-oxide (1.0 g; 8.7 mmol) in CH_2Cl_2 (20 ml) at rt was treated with a catalytic amount of tetra-*n*-propylammonium perruthenate, and the resulting black suspension was stirred for 3 h. The reaction mixture was then filtered through a pad of silica gel (ether rinse), and the filtrate was concentrated in vacuo. Purification of the residue by flash chromatography (silica, 10% ether:hexanes) afforded ketone **15** (924 mg; 93%) as a light yellow oil.

EXAMPLE 7

Alkene 17: A cooled (-78°C) solution of phosphine oxide **16** (1.53 g; 4.88 mmol) in THF (15.2 ml) was treated with *n*-butyllithium (1.79 ml of a 2.45 M solution in hexanes). After 15 min, the orange solution was treated with a solution of ketone **15** (557 mg; 2.44 mmol) in THF (4.6 ml). After 10 min, the cooling bath was removed, and the solution was allowed to warm to rt. The formation of a precipitate was observed as the solution warmed. The reaction was quenched by the addition of saturated aqueous ammonium chloride solution (20 ml). The mixture was then poured into ether (150 ml) and washed successively with water (50 ml) and brine (50 ml). The organic layer was dried (Na_2SO_4), filtered, and concentrated. Purification

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of the residue by flash chromatography (silica, 10% ether:hexanes) afforded alkene **17** (767 mg; 97%) as a colorless oil: IR(film): 2956, 2177, 1506, 1249, 1149, 1032, 842, cm^{-1} ; ^1H NMR(CDCl_3 , 500MHz) δ 6.95(s, 1H), 6.53(s, 1H), 4.67(d, J = 6.7Hz, 1H), 4.57(d, J = 6.8Hz, 1H), 4.29(dd, J = 8.1, 5.4 Hz, 1H), 3.43(s, 3H), 2.70(s, 3H), 2.62(dd, J = 16.9, 8.2Hz, 1H), 2.51(dd, J = 17.0, 5.4Hz, 1H), 2.02(s, 3H); ^{13}C NMR(CDCl_3 , 125 MHz) δ 164.4, 152.5, 137.1, 121.8, 116.2, 103.7, 93.6, 86.1, 79.6, 55.4, 25.9, 19.1, 13.5; $[\alpha]_D$ = -27.3 (c = 2.2, CHCl_3).

EXAMPLE 8

Alkynyl iodide formation: To a solution of the alkyne **17** (3.00 g, 9.29 mmol) in acetone (100 mL) at 0°C was added NIS (2.51 g; 11.2 mmol) and AgNO_3 (0.160 g; 0.929 mmol). The mixture was then slowly warmed to rt. After 1.5 h, the reaction was poured into Et_2O (250 mL) and washed once with sat bisulfite (40 mL), once with sat NaHCO_3 (40 mL), once with brine (40 mL) and dried over anhydrous MgSO_4 . Purification by flash chromatography on silica gel using gradient elution with hexanes/ethyl acetate (10:1 - 7:1) gave 2.22 g (64%) of the iodide **17a** as an amber oil.

EXAMPLE 9

Reduction of the alkynyl iodide: $\text{BH}_3 \cdot \text{DMS}$ (0.846 mL, 8.92 mmol) was added to a solution of cyclohexene (1.47 mL, 17.9 mmol) in Et_2O (60 mL) at 0°C. The reaction was then warmed to rt. After 1 h, the iodide **17a** (2.22 g, 5.95 mmol) was added to Et_2O . After 3 h, AcOH (1.0 mL) was added. After 30 additional min, the solution was poured into sat NaHCO_3 and extracted with Et_2O (3 x 100 mL). The combined organics were then washed once with brine (50 mL) and dried over anhydrous MgSO_4 . Purification by flash chromatography on silica gel eluting with hexanes/ethyl acetate (6:1) gave 1.45 g (65%) of the vinyl iodide **18** as a yellow oil.

EXAMPLE 10

MOM removal: To a solution of iodide **18** (1.45 g, 3.86 mmol) in CH_2Cl_2 (40 mL) at rt was added thiophenol (1.98 mL, 19.3 mmol) and $\text{BF}_3 \cdot \text{OEt}_2$ (1.90 mL, 15.43 mmol). After 22h, the reaction was poured into EtOAc (150 mL) and washed with 1N NaOH (2 x 50 mL) and dried over anhydrous MgSO_4 . Purification by flash chromatography on silica gel using gradient elution with hexanes/ethyl acetate (4:1 - 2:1 - 1:1) gave 1.075 g (86%) of the alcohol **18a** as a pale yellow oil.

EXAMPLE 11

Acetate formation: To a solution of alcohol **18a** (1.04 g, 3.15 mmol) in CH_2Cl_2 (30 mL) was added pyridine (2.52 mL, 25.4 mmol), acetic anhydride (1.19 mL, 12.61 mmol) and DMAP (0.005 g). After 1 h, the volatiles were removed in vacuo. Purification of the resulting residue by flash chromatography on silica gel eluting with hexanes/ethyl acetate (7:1) gave 1.16 g (99%) of the acetate **19** as a pale yellow oil. IR(film): 1737, 1368, 1232, 1018 cm^{-1} ; ^1H

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NMR (CDCl₃, 500MHz) δ 6.97 (s, 1H), 6.53 (s, 1H), 6.34 (dd, J = 17.5, 1.0 Hz, 1H), 6.18 (dd, J = 13.7, 6.9 Hz, 1H), 5.40 (t, J = 6.4 Hz, 1H), 2.70 (s, 3H), 2.61 (m, 2H), 2.08 (2s, 6H). ¹³C NMR (CDCl₃, 125 MHz) δ 169.8, 164.4, 152.2, 136.4, 136.1, 120.6, 116.4, 85.1, 38.3, 21.0, 19.1, 14.7; $[\alpha]_D$ = -28.8 (c = 1.47, CHCl₃).

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EXAMPLE 12

To a solution of alcohol 4 (2.34 g, 3.62 mmol) and 2,6-lutidine (1.26 mL, 10.86 mmol) in CH₂Cl₂ (23 mL) at 0 °C was treated with TBSOTf (1.0 mL, 4.34 mmol). After stirring for 1.5 h at 0 °C the reaction mixture was quenched with MeOH (200 μ L) and the mixture stirred an additional 5 min. The reaction mixture was diluted with Et₂O (100 mL) and washed successively with 1 N HCl (25 mL), water (25 mL), and brine (25 mL). The solution was dried over MgSO₄, filtered, and concentrated. The residue was purified by flash chromatography on silica gel eluting with 5% Et₂O in hexanes to provide compound 7 (2.70 g, 98%) as a colorless foam.

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EXAMPLE 13

A solution of compound 7 (2.93 g, 3.85 mmol) in CH₂Cl₂/H₂O (20:1, 80 mL) was treated with DDQ (5.23 g, 23.07 mmol) and the resulting suspension was stirred at room temperature for 24 h. The reaction mixture was diluted with Et₂O (200 mL) and washed with aqueous NaHCO₃ (2 x 40 mL). The aqueous layer was extracted with Et₂O (3 x 40 mL) and the combined organic fractions were washed with brine (50 mL), dried over MgSO₄, filtered, and concentrated. Purification of the crude oil by flash chromatography on silica gel eluting with 30% ether in hexanes afforded alcohol 7A (2.30 g, 89%) as a colorless oil: IR (film) 3488, 1471, 1428, 1115, 1054 cm⁻¹; ¹H NMR (CDCl₃, 500 MHz) δ 7.70 (6 H, dd, J = 8.0, 1.5 Hz), 7.44 (9 H, s), 4.57 (1 H, d, J = 3.5 Hz), 4.19 (1 H, s), 3.67 (1 H, d, J = 8.5 Hz), 3.06 (1 H, dd, J = 11.5, 5.0 Hz), 2.89 (1 H, dd, J = 11.5, 5.0 Hz), 2.68 (1 H, d, J = 13.5 Hz), 2.59 (1 H, d, J = 13.5 Hz), 2.34 (1 H, dt, J = 12.0, 2.5 Hz), 2.11 (1 H, m), 1.84 (1 H, dt, J = 12.0, 2.5 Hz), 1.76 (2 H, m), 1.59 (2 H, m), 1.34 (3 H, s), 1.13 (3 H, d, J = 7.5 Hz), 1.10 (3 H, s), 0.87 (9 H, s), 0.84 (3 H, d, J = 12.0 Hz), 0.02 (3 H, s), 0.01 (3 H, s); ¹³C NMR (CDCl₃, 125 MHz) δ 136.18, 134.66, 130.16, 127.84, 78.41, 75.91, 63.65, 59.69, 45.43, 45.09, 37.72, 30.84, 30.50, 26.23, 25.89, 22.42, 21.05, 18.40, 15.60, 14.41, -3.23, -3.51; $[\alpha]_D$ = -0.95 (c = 0.173, CHCl₃).

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EXAMPLE 14

To a solution of oxalyl chloride (414 μ L, 4.74 mmol) in CH₂Cl₂ (40 mL) at -78 °C was added dropwise DMSO (448 μ L, 6.32 mmol) and the resulting solution was stirred at -78 °C for 30 min. Alcohol 7a (2.12 g, 3.16 mmol) in CH₂Cl₂ (20 mL) was added and the resulting white suspension was stirred at -78 °C for 45 min. The reaction mixture was quenched with Et₃N (2.2 mL, 15.8 mmol) and the solution was allowed to warm to 0 °C and stirred at this temperature for 30 min. The reaction mixture was diluted with Et₂O (100 mL) and washed

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successively with aqueous NH_4Cl (20 mL), water (20 mL), and brine (20 mL). The crude aldehyde was purified by flash chromatography on silica gel eluting with 5% Et_2O in hexanes to provide aldehyde **8** (1.90 g, 90%) as a colorless oil.

EXAMPLE 15

- 5 A solution of (methoxymethyl)triphenylphosphonium chloride (2.97 g, 8.55 mmol) in THF (25 mL) at 0 °C was treated with KO^tBu (8.21 mL, 1M in THF, 8.1 mmol). The mixture was stirred at 0 °C for 30 min. Aldehyde **8** (3.1 g, 4.07 mmol) in THF (10 mL) was added and the resulting solution was allowed to warm to room temperature and stirred at this temperature for 2 h. The reaction mixture was quenched with aqueous NH_4Cl (40 mL) and the resulting
10 solution extracted with Et_2O (3 x 30 mL). The combined Et_2O fractions were washed with brine (20 mL), dried over MgSO_4 , filtered, and concentrated. The residue was purified by flash chromatography on silica gel eluting with 5% Et_2O in hexanes to yield compound **9** (2.83 g, 86%) as a colorless foam.

EXAMPLE 16

- 15 To a solution of compound **9** (2.83g, 3.50 mmol) in dioxane/ H_2O (9:1, 28 mL) was added pTSA· H_2O (1.0 g, 5.30 mmol) and the resulting mixture was heated to 50 °C for 2 h. After cooling to room temperature the mixture was diluted with Et_2O (50 mL) and washed with aqueous NaHCO_3 (15 mL), brine (20 mL), dried over MgSO_4 , filtered, and concentrated to provide aldehyde **9a** (2.75 g, 99%) as a colorless foam.

EXAMPLE 17

- 20 Methyltriphenylphosphonium bromide (1.98 g, 5.54 mmol) in THF (50 mL) at 0 °C was treated with lithium bis(trimethylsilyl)amide (5.04 mL, 1M in THF, 5.04 mmol) and the resulting solution was stirred at 0 °C for 30 min. Aldehyde **9a** (2.0 g, 2.52 mmol) in THF (5.0 mL) was added and the mixture was allowed to warm to room temperature and stirred at this
25 temperature for 1 h. The reaction mixture was quenched with aqueous NH_4Cl (15 mL) and extracted with Et_2O (3 x 20 mL). The combined Et_2O fractions were washed with brine (15 mL), dried over MgSO_4 , filtered, and concentrated. The residue was purified by flash chromatography on silica gel eluting with 5% Et_2O in hexanes to afford compound **10** (1.42 g, 76%) as a colorless foam.

EXAMPLE 18

- 30 A solution of compound **10** (1.0 g, 1.34 mmol) in MeOH/THF (2:1, 13 mL) was treated with [bis(trifluoroacetoxy)iodobenzene] (865 mg, 2.01 mmol) at room temperature. After 15 min the reaction mixture was quenched with aqueous NaHCO_3 (25 mL). The mixture was extracted with Et_2O (3 x 25 mL) and the combined Et_2O fractions were washed with brine,
35 dried over MgSO_4 , filtered, and concentrated. Purification of the residue by flash chromatography on silica gel eluting with 5% Et_2O in hexanes provided compound **11** (865 mg, 92%) as a colorless foam: IR (film) 1428, 1252, 1114, 1075, 1046 cm^{-1} ; ^1H NMR (CDCl_3 ,

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500 MHz) δ 7.61 (6 H, dd, $J = 7.9, 1.4$ Hz), 7.38 (9 H, s), 5.47 (1 H, m), 4.87 (1 H, d, $J = 10.0$ Hz), 4.76 (1 H, d, $J = 15.9$ Hz), 4.30 (1 H, d, $J = 3.7$ Hz), 3.95 (1 H, s), 3.56 (1 H, dd, $J = 7.5, 1.4$ Hz), 3.39 (3 H, s), 2.84 (3 H, s), 2.02 (1 H, m), 1.64 (2 H, m), 1.34 (1 H, m), 1.11 (3 H, s), 1.02 (3 H, d, $J = 7.4$ Hz), 0.90 (3 H, s), 0.85 (9 H, s), 0.62 (3 H, d, $J = 6.8$ Hz), -0.04 (3 H, s), -0.05 (3 H, s); ^{13}C NMR (CDCl_3 , 125 MHz) δ 138.29, 135.79, 135.04, 129.86, 127.78, 114.98, 110.49, 60.11, 55.57, 46.47, 43.91, 36.82, 34.21, 26.26, 19.60, 18.60, 17.08, 16.16, 13.92, -2.96, -3.84; $[\alpha]_D = +1.74$ ($c = 0.77$, CHCl_3).

EXAMPLE 19

Suzuki Coupling: To a solution of olefin **11** (0.680 g, 1.07 mmol) in THF (8.0 mL) was added 9-BBN (0.5 M soln in THF, 2.99 mL, 1.50 mmol). In a separate flask, the iodide **19** (0.478 g, 1.284 mmol) was dissolved in DMF (10.0 mL). CsCO_3 (0.696 g, 2.14 mmol) was then added with vigorous stirring followed by sequential addition of Ph_3As (0.034 g, 0.111 mmol), $\text{PdCl}_2(\text{dppf})_2$ (0.091 g, 0.111 mmol) and H_2O (0.693 mL, 38.5 mmol). After 4 h, then borane solution was added to the iodide mixture in DMF. The reaction quickly turned dark brown in color and slowly became pale yellow after 2 h. The reaction was then poured into H_2O (100 mL) and extracted with Et_2O (3 x 50 mL). The combined organics were washed with H_2O (2 x 50 mL), once with brine (50 mL) and dried over anhydrous MgSO_4 . Purification by flash chromatography on silica gel eluting with hexanes/ethyl acetate (7:1) gave 0.630 g (75%) of the coupled product **20** as a pale yellow oil.

EXAMPLE 20

Hydrolysis of dimethyl acetal 21: The acetate **20** (0.610 g, 0.770 mmol) was dissolved in dioxane/ H_2O (9:1, 15 mL) and $p\text{-TSA} \cdot \text{H}_2\text{O}$ (0.442 g, 2.32 mmol) was added. The mixture was then heated to 55°C . After 3 h, the mixture was cooled to rt and poured into Et_2O . This solution was washed once with sat NaHCO_3 (30 mL), once with brine (30 mL) and dried over anhydrous MgSO_4 . Purification by flash chromatography on silica gel eluting with hexanes/ethyl acetate (7:1) gave 0.486 g (85%) of the aldehyde **21** as a pale yellow oil. IR (film) 1737, 1429, 1237, 1115, 1053 cm^{-1} ; ^1H NMR (CDCl_3 , 500 MHz) δ 9.74 (1 H, s), 7.61 (6 H, dd, $J = 7.8, 1.2$ Hz), 7.38 (9 H, m), 6.94 (1 H, s), 6.53 (1 H, s), 5.39 (1 H, m), 5.31 (1 H, m), 5.29 (1 H, t, $J = 6.9$ Hz), 4.61 (1 H, d, $J = 4.3$ Hz), 3.50 (1 H, dd, $J = 5.2, 2.6$ Hz), 2.70 (3 H, s), 2.48 (2 H, m), 2.14 (1 H, m), 2.09 (3 H, s), 2.07 (3 H, s), 1.83 (2 H, m), 1.41 (1 H, m), 1.18 (1 H, m), 1.01 (3 H, s), 0.99 (3 H, s), 0.91 (3 H, d, $J = 7.4$ Hz), 0.85 (9 H, s), 0.69 (1 H, m), 0.58 (3 H, d, $J = 6.8$ Hz), -0.05 (3 H, s), -0.06 (3 H, s); ^{13}C NMR (CDCl_3 , 125 MHz) δ 205.46, 170.01, 164.49, 152.46, 137.10, 135.60, 134.22, 132.55, 130.65, 127.84, 123.82, 120.66, 116.19, 81.09, 78.47, 76.73, 51.66, 43.14, 38.98, 30.99, 30.42, 27.63, 26.10, 21.15, 20.92, 20.05, 19.15, 18.49, 15.12, 14.70, 12.75, -3.25, -4.08; $[\alpha]_D = -18.7$ ($c = 0.53$, CHCl_3).

EXAMPLE 21

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- Aldol: To a solution of the acetate-aldehyde **21** (84 mg, 0.099 mmol) in THF at -78°C was added KHMDS (0.5M in toluene, 1.0 ml, 0.5 mmol) dropwise. The resulting solution was stirred at -78°C for 30 min. Then the reaction mixture was cannulated to a short pad of silica gel and washed with ether. The residue was purified by flash chromatography (silica, 12% EtOAc in hexane) to give the lactone **22** (37 mg of 3-S and 6 mg of 3-R, 51%) as white foam.

EXAMPLE 22

- Monodeprotection: Lactone **22** (32 mg, 0.0376 mmol) was treated with 1 ml of pyridine buffered HF-pyridine - THF solution at room temperature for 2 h. The reaction mixture was poured into saturated aqueous NaHCO₃ and extracted with ether. The organic layer was washed in sequence with saturated CuSO₄ (10 ml x 3) and saturated NaHCO₃ (10 ml), then dried over Na₂SO₄ and concentrated under vacuum. The residue was purified by flash chromatography (silica, 25% EtOAc in hexane) and to give diol **22a** (22 mg, 99%) as white foam.

EXAMPLE 23

- TBS-protection: To a cooled (-30°C) solution of diol **22a** (29 mg, 0.0489 mmol) and 2,6-lutidine (0.017 ml, 0.147 mmol) in anhydrous CH₂Cl₂ (1 ml) was added TBSOTf (0.015 ml, 0.0646 mmol). The resulting solution was then stirred at -30°C for 30 min. The reaction was quenched with 0.5M HCl (10 ml) and extracted with ether (15 ml). Ether layer was washed with saturated NaHCO₃, dried (Na₂SO₄) and concentrated in vacuo. Purification of the residue by flash chromatography (silica, 8% EtOAc in hexane) afforded TBS ether **22B** (32 mg, 93%) as white foam.

EXAMPLE 24

- Ketone Formation: To a solution of alcohol **22B** (30 mg, 0.0424 mmol) in CH₂Cl₂ (2.0 mL) at 25°C was added Dess-Martin periodinane (36 mg, 0.0848 mmol) in one portion. The resulting solution was then allowed to stir at 25°C for 1.5 h. The reaction was quenched by the addition of 1:1 saturated aqueous sodium bicarbonate: sodium thiosulfate (10 ml) and stirred for 5 min. The mixture was then extracted with ether (3 x 15 ml). The organic layer was dried (Na₂SO₄), filtered, and concentrated in vacuo. Purification of the residue by flash chromatography (silica, 8% EtOAc in hexane) provided ketone **22C** (25 mg, 84%) as white foam. IR(film): 2928, 1745, 1692, 1254, 1175, 836 cm⁻¹; ¹H NMR(CDCl₃, 500 MHz) δ 6.97 (s, 1H), 6.57 (s, 1H), 5.53 (dt, *J* = 3.4, 11.1 Hz, 1H), 5.37 (dd, *J* = 16.4, 9.9 Hz, 1H), 5.00 (d, *J* = 10.3 Hz, 1H), 4.02 (d, *J* = 9.7 Hz, 1H), 3.89 (d, *J* = 8.7 Hz, 1H), 3.00 (m, 1H), 2.82 (d, *J* = 6.5 Hz, 1H), 2.71 (m, 5H), 2.36 (q, *J* = 10.7 Hz, 1H), 2.12 (, 3H), 2.07 (dd, *J* = 8.2, 1H), 1.87 (bs, 1H), 1.49 (m, 3H), 1.19 (m, 5H), 1.14 (s, 3H), 1.08 (d, *J* = 6.8 Hz, 3H), 0.94 (m, 12H), 0.84 (s, 9H), 0.12 (s, 3H), 0.10 (s, 3H), 0.07 (s, 3H), -0.098 (s, 3H); ¹³C NMR (CDCl₃, 125 MHz) δ 218.7, 170.1, 164.5, 152.6, 137.9, 133.9, 124.8, 119.6, 115.9, 72.7, 53.2, 43.9, 41.0, 40.3, 32.9, 32.3, 28.4,

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27.1, 26.3, 26.1, 26.0, 19.2, 19.1, 18.3, 18.2, 17.1, 16.0, 15.2, 14.3, -4.2, -4.4, -4.6, -4.8 ;
[α]_D = -21.93 (c = 1.4, CHCl₃).

EXAMPLE 25

Desoxy compound: To a solution of TBS ether **22C** (27 mg, 0.038 mmol) in THF (1 ml) at 25°C
5 in a plastic vial was added dropwise HF-pyridine (0.5 ml). The resulting solution was allowed
to stir at 25°C for 2 h. The reaction mixture was diluted with chloroform (2 ml) and very
slowly added to saturated sodium bicarbonate (20 ml). The mixture was extracted with CHCl₃
(20 ml x 3). The organic layer was dried (Na₂SO₄), filtered, and concentrated in vacuo.
Purification of the residue by flash chromatography (silica, 30% EtOAc in hexane) provided
10 diol **23** (18 mg, 99%) as white foam: IR(film): 3493, 2925, 1728, 1689, 1249 cm⁻¹; ¹H NMR
(CDCl₃, 500 MHz) δ 6.96 (s, 1H), 6.59 (s, 1H), 5.44 (dt, *J* = 4.3, 10.4 Hz, 1H), 5.36 (dt, *J* = 5.1,
10.2 Hz, 1H), 5.28 (dd, *J* = 1.7, 9.8 Hz, 1H), 4.11 (d, *J* = 7.2 Hz, 1H), 3.74 (s, 1H), 3.20 (d,
J = 4.5 Hz, 1H), 3.14 (dd, *J* = 2.2, 6.8 Hz, 1H), 3.00 (s, 1H), 2.69 (m, 4H), 2.49 (dd, *J* = 11.3,
15.1 Hz, 1H), 2.35 (dd, *J* = 2.5, 15.1 Hz, 1H), 2.27 (m, 1H), 2.05 (m, 1H), 2.04 (s, 3H), 2.01
15 (m, 1H), 1.75 (m, 1H), 1.67 (m, 1H), 1.33 (m, 4H), 1.21 (s, 1H), 1.19 (m, 2H), 1.08 (d, *J* = 7.0
Hz, 3H), 1.00 (s, 3H), 0.93 (d, *J* = 7.1 Hz, 3H); ¹³C NMR (CDCl₃, 125 MHz) δ 226.5, 176.5,
171.1, 158.2, 144.7, 139.6, 131.1, 125.7, 122.0, 84.6, 80.2, 78.6, 59.4, 47.9, 45.4, 44.6, 38.5,
37.9, 33.7, 33.6, 28.7, 25.1, 25.0, 21.9, 21.7, 19.6; [α]_D = -84.7 (c = 0.85, CHCl₃).

EXAMPLE 26

20 Epothilone: To a cooled (-50°C) solution of desoxyepothilone (9 mg, 0.0189 mmol) in dry
CH₂Cl₂ (1 ml) was added freshly prepared dimethyldioxirane (0.95 ml, 0.1 M in acetone). The
resulting solution was allowed to warm up to -30°C for 2 h. A stream of nitrogen was then
bubbled through the solution to remove excess DMDO. The residue was purified by flash
chromatography (silica, 40% EtOAc in hexane) and afforded epothilone A (4.6 mg, 49%) as
25 colorless solid and 0.1 mg of cis-epoxide diastereomer. This material was identical with the
natural epothilone A in all respects.

EXAMPLE 27

Procedure for Ring-closing Olefin Metathesis:

To a stirred solution of diene **24** (5 mg, 0.0068 mmol) in dry benzene (1.5 mL) was added
30 Grubbs's catalyst (2.8 mg, 0.0034 mmol). After 12 h, an additional portion of catalyst was
added (2.8 mg). After an additional 5 h, the reaction was concentrated. Purification by silica
gel chromatography eluting with hexanes/ethyl acetate (11:1) gave the lactone **23** (3.5 mg,
94%, 2:1 E/Z).

EXAMPLE 28

Preparation of Compound 19:

Alcohol **2A**: A mixture of (S)-(-)-1,1'-bi-2-naphthol (259 mg, 0.91 mmol), Ti(O-*i*-Pr)₄ (261
μL, 0.90 mmol), and 4 Å sieves (3.23 g) in CH₂Cl₂ (16 mL) was heated at reflux for 1 h. The

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mixture was cooled to rt and aldehyde 1 was added. After 10 min. the suspension was cooled to -78 °C, and allyl tributyltin (3.6 mL; 11.60 mmol) was added. The reaction mixture was stirred for 10 min at -78 °C and then placed in a -20 °C freezer for 70 h. Saturated NaHCO₃ (2mL) was added, and the mixture was stirred for 1 h, poured over Na₂SO₄, and then filtered through a pad of MgSO₄ and celite. The crude material was purified by flash chromatography (hexanes/ethyl acetate, 1:1) to give alcohol 2A as a yellow oil (1.11g; 60%).

EXAMPLE 29

Acetate 3A: To a solution of alcohol 2A (264 mg; 1.26 mmol) in CH₂Cl₂ (12 mL) was added DMAP (15mg; 0.098 mmol), Et₃N (0.45 mL; 3.22 mmol), and Ac₂O (0.18 mL; 1.90 mmol). After 2h, the reaction mixture was quenched by 20 mL of H₂O, and extracted with EtOAc (4 x 20 mL). The combined organic layer was dried with MgSO₄, filtered, and concentrated. Flash chromatography (EtOAc/hexanes, 1:3) afforded acetate 3A as a yellow oil (302 mg; 96%).

EXAMPLE 30

Vinyl Iodide 19: To a solution of acetate 3A (99 mg; 0.39 mmol) in acetone at 0 °C was added H₂O (4 drops), OsO₄ (2.5% wt. in butyl alcohol; 175 µL; 0.018 mmol), and N-methyl-morpholine-N-oxide (69 mg; 0.59 mmol). The mixture was stirred at 0 °C for 2h and 45 min and then quenched with Na₂SO₃. The solution was poured to 10 mL of H₂O and extracted with EtOAc (5 x 10mL). The combined organic layer was dried over MgSO₄, filtered, and concentrated.

To a solution of this crude product in THF/H₂O (4 mL, 3:1) was added NaIO₄ (260 mg; 1.22 mmol). After 1.25 h, the reaction mixture was then quenched with 10 mL of H₂O and concentrated. The residue was extracted with EtOAc (5 x 10mL). The organic layer was dried over MgSO₄, filtered, and concentrated. Flash chromatography (EtOAc/hexanes, 1:1) gave a yellow oil (80 mg) which contained unidentified by-product(s). This mixture was used without further purification.

To a solution of (Ph₃P⁺CH₂I)⁻ (100 mg; 0.19 mmol) in 0.25 mL of THF at rt was added 0.15 mL (0.15 mmol) of NaHMDS (1M in THF). To the resulting solution at -78 °C was added HMPA (22 µL; 0.13 mmol) and the product from previous step (16 mg) in THF (0.25 mL). The reaction mixture was then stirred at rt for 30 min. After the addition of hexanes (10mL), the solution was extracted with EtOAc (4 x 10mL). The combined EtOAc layer was dried (MgSO₄), filtered, and concentrated. Preparative TLC (EtOAc/hexanes, 2:3) afforded vinyl iodide 19 as a yellow oil (14 mg; 50% for three steps).

EXAMPLE 31

Iodoolefin acetate 8C: To a suspension of ethyltriphenylphosphonium iodide (1.125 g, 2.69 mmol) in THF (10 mL) was added nBuLi (2.5 M soln in hexanes, 1.05 mL, 2.62 mmol) at rt. After disappearance of the solid material, the solution was added to a mixture of iodine (0.613

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g, 2.41 mmol) in THF (20 mL) at -78 °C. The resulting suspension was vigorously stirred for 5 min at -78 °C, then warmed up -20 °C, and treated with sodium hexamethyldisilazane (1 M soln in THF, 2.4 mL, 2.4 mmol). The resulting red solution was stirred for 5 min followed by the slow addition of aldehyde **9C** (0.339 g, 1.34 mmol). The mixture was stirred at -20 °C for 40 min, diluted with pentane (50 mL), filtered through a pad of celite, and concentrated. Purification of the residue by flash column chromatography (hexanes/ethyl acetate, 85:15) gave 0.202 g (25% overall from vinyl acetate **10C**) of the vinyl iodide **8C** as a yellow oil. IR (film): 2920, 1738, 1234 cm⁻¹; ¹H NMR (CDCl₃): δ 6.98 (s, 1H), 6.56 (s, 1H), 5.42 (dd, *J* = 5.43, 6.57 Hz, 1H), 5.35 (t, *J* = 6.6 Hz, 1H), 2.71 (s, 3H), 2.54 (q, *J* = 6.33, 2H), 2.50 (s, 3H), 2.09 (s, 6H); ¹³C NMR (CDCl₃): δ 170.1, 164.6, 152.4, 136.9, 130.2, 120.6, 116.4, 103.6, 40.3, 33.7, 21.2, 19.2, 14.9; [α]_D = -20.7 ° (c = 2.45, CHCl₃).

EXAMPLE 32

Acetal 13C: To a solution of olefin "7C" (0.082 g, 0.13 mmol) in THF (0.5 mL) was added 9-BBN (0.5 M soln in THF, 0.4 mL, 0.2 mmol). After stirring at rt. for 3.5 h, an additional portion of 9-BBN (0.5 M soln in THF, 0.26 mL, 0.13 mmol) was added. In a separate flask, iodide **8C** (0.063 g, 0.16 mmol) was dissolved in DMF (0.5 mL). Cs₂CO₃ (0.097 g, 0.30 mmol) was then added with vigorous stirring followed by sequential addition of PdCl₂(dppf)₂ (0.018 g, 0.022 mmol), Ph₃As (0.0059 g, 0.019 mmol), and H₂O (0.035 mL, 1.94 mmol). After 6 h, then borane solution was added to the iodide mixture in DMF. The reaction quickly turned dark brown in color and slowly became pale yellow after 3 h. The reaction was then poured into H₂O (10 mL) and extracted with Et₂O (3 x 15 mL). The combined organic layers were washed with H₂O (3 x 15 mL), brine (1 x 20 mL), dried over MgSO₄, filtered, and concentrated. Flash column chromatography (hexanes/ethyl acetate, 9:1) gave 0.089 g (77%) of the coupled product **13C** as a yellow oil.

EXAMPLE 33

Aldehyde 14C: Acetal **13C** (0.069 g, 0.077 mmol) was dissolved in dioxane/H₂O (9:1, 1 mL) and pTSA·H₂O (0.045 g, 0.237 mmol) was added. The mixture was then heated to 55°C. After 3 h, the mixture was cooled to rt, poured into Et₂O, and extracted with Et₂O (4 x 15 mL). The combined ether solutions were washed with sat NaHCO₃ (1 x 30 mL), brine (1 x 30 mL), dried over MgSO₄, filtered, and concentrated. Flash column chromatography (hexanes/ethyl acetate, 3:1) gave 0.046 g (71%) of the aldehyde **14C** as a pale yellow oil.

EXAMPLE 34

Macrocycle 15C-(SR): To a solution of aldehyde **14C** (0.021 g, 0.024 mmol) in THF (5 mL) at -78 °C was added KHMDS (0.5 M soln in toluene, 0.145 mL, 0.073 mmol). The solution was stirred at -78 °C for 1 h, then quenched with sat'd NH₄Cl, and extracted with ether (3 x 15 mL). The combined organic layers were dried with MgSO₄, filtered, and concentrated. Flash column chromatography (hexanes/ethyl acetate, 7:1) gave 0.008 g of the desired α-

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alcohol **15C-(S)** and 0.006 g of β -alcohol **15C-(R)** (67% total) as pale yellow oils.

EXAMPLE 35

Macrocycle **15C-(S)**: To a solution of β -alcohol **15C-(R)** (0.006 g, 0.0070 mmol) in 0.5 mL of CH_2Cl_2 at rt. was added Dess-Martin periodinane (0.028g, 0.066 mmol). After 0.5 h, an additional portion of Dess-Martin periodinane (0.025 mg, 0.059 mmol) was added. The resulting solution was stirred at rt for additional 1 h, then treated with ether (2 mL) and sat'd $\text{Na}_2\text{S}_2\text{O}_3$ /sat'd NaHCO_3 (3 mL, 1:1), poured into H_2O (20 mL), and extracted with ether (4 x 10 mL). The combined ether solutions were washed with H_2O (1 x 30 mL), brine (1 x 30 mL), dried with MgSO_4 , filtered, and concentrated. To a solution of crude ketone **15C'** in MeOH/THF (2 mL, 1:1) at -78 °C was added NaBH_4 (0.015 g, 0.395 mmol). The resulting solution was stirred at rt for 1 h, quenched with sat NH_4Cl , and extracted with ether (3 x 15 mL). The organic layers were dried with MgSO_4 , filtered, and concentrated. Flash column chromatography (hexanes/ethyl acetate, 9:1) gave 0.0040 g (67%) of the α -alcohol **15C-(S)** as a pale yellow oil and 0.0006 g of β -alcohol **15C-(R)**.

EXAMPLE 36

Diol **15C''**: The silyl ether **15C-(S)** (0.010 g, 0.012 mmol) was dissolved in HF-pyridine/pyridine/THF (1 mL). The solution was stirred at rt. for 2 h, then diluted with Et_2O (1 mL), poured into a mixture of Et_2O /sat. NaHCO_3 (20 mL, 1:1), and extracted with Et_2O (4 x 10 mL). The Et_2O solutions were washed with sat CuSO_4 (3 x 30 mL), sat NaHCO_3 (1 x 30 mL), brine (1 x 30 mL), dried with MgSO_4 , filtered, and concentrated. Flash column chromatography (hexanes/ethyl acetate, 9:1) gave 0.0066 g (93%) of the diol **15C''** as a pale yellow oil.

EXAMPLE 37

Alcohol **15C'''**: To a solution of diol **15C''** (0.0066 g, 0.011 mmol) in 0.5 mL of CH_2Cl_2 at -78 °C was added 2,6-lutidine (7 μL , 0.060 mmol) and TBSOTf (5 μL , 0.022 mmol). The resulting solution was stirred at -30 °C for 0.5 h, then quenched with H_2O (5 mL), and extracted with Et_2O (4 x 10 mL). The ether solutions were washed with 0.5 M HCl (1 x 10 mL), sat'd NaHCO_3 (1 x 10 mL), dried over MgSO_4 , filtered, and concentrated. Flash column chromatography (hexanes/ethyl acetate, 93:7) gave 0.0070 g (89%) of the alcohol **15C'''** as a pale yellow oil.

EXAMPLE 38

Ketone **16C**: To a solution of alcohol **15C'''** (0.006 g, 0.0083 mmol) in 0.5 mL of CH_2Cl_2 at rt. was added Dess-Martin periodinane (0.030g, 0.071 mmol). After 1.25 h, another portion of Dess-Martin periodinane (0.025 mg, 0.059 mmol) was added. The resulting solution was stirred at rt for additional 0.75 h, treated with ether (1 mL) and sat'd $\text{Na}_2\text{S}_2\text{O}_3$ /sat'd NaHCO_3 (2 mL, 1:1), poured into H_2O (20 mL), and extracted with ether (4 x 10 mL). The ether solution was washed with sat NaHCO_3 (1 x 20 mL), dried with MgSO_4 , filtered, and

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concentrated. Flash column chromatography (hexanes/ethyl acetate, 9:1) gave 0.0040 g (67%) of the ketone **16C** as a pale yellow oil.

EXAMPLE 39

Desoxyepothilone B 2C: To a solution of ketone **16C** (0.004 g, 0.0056 mmol) in THF (0.35 mL) was added HF-pyridine (0.25 mL) dropwise over 20 min. The solution was stirred at rt for 1.5 h, diluted with CHCl₃ (2 mL), poured into sat'd NaHCO₃/CHCl₃ (20 mL, 1:1) slowly, and extracted with CHCl₃ (4 x 10 mL). The combined CHCl₃ layers were dried with MgSO₄, filtered, and concentrated. Flash column chromatography (hexanes/ethyl acetate, 3:1) gave 0.0022 g (80%) of the desoxyepothilone B **2C** as a pale yellow oil.

EXAMPLE 40

Epothilone B 2: To a solution of desoxyepothilone B (0.0022 g, 0.0041 mmol) in CH₂Cl₂ (0.25 mL) at -50 °C was added dimethyldioxirane (0.1 mL, 0.0095 mmol) dropwise. The resulting solution was stirred at -50 °C for 1 h. The dimethyldioxirane and solvent were removed by a stream of N₂. The residue was purified by flash column chromatography (hexanes/ethyl acetate, 1:1) gave 0.0015 g (70%) of epothilone B (**2**) as a pale yellow oil which was identical with an authentic sample in ¹H NMR, IR, mass spectrum, and [α]_D.

EXAMPLE 41

8-Desmethylepothilone A

Crotylation product: To a stirred mixture of potassium *tert*-butoxide (1.0 M soln in THF, 50.4 mL, 50.4 mmol), THF (14 mL), and *cis*-2-butene (9.0 mL, 101 mmol) at -78 °C was added *n*-BuLi (1.6 M, in hexanes, 31.5 mL, 50.4 mmol). After complete addition of *n*-BuLi, the mixture was stirred at -45 °C for 10 min and then cooled to -78 °C. (+)-*B*-Methoxydiisopinocampheylborane (19.21 g, 60.74 mmol) was then added dropwise in Et₂O (10 mL). After 30 min, BF₃·Et₂O (7.47 mL, 60.74 mmol) was added followed by aldehyde **4D** (9.84 g, 60.74 mmol) in THF (15 mL) generating a viscous solution which could not be stirred. The mixture was shaken vigorously every 10 min to ensure homogeneity. After 3 h at -78 °C, the reaction was treated with 3N NaOH (36.6 mL, 110 mmol) and 30% H₂O₂ (15 mL) and the solution brought to reflux for 1 h. The reaction was poured into Et₂O (300 mL) and washed with H₂O (100 mL), brine (30 mL) and dried over anhydrous MgSO₄. The crude material was placed in a bulb-to-bulb distillation apparatus to remove the ligand from the desired product. Heating at 80 °C at 2 mm Hg removed 90% of the lower boiling ligand. Further purification of the alcohol **4D** was achieved by flash chromatography on silica gel eluting with Et₂O in CH₂Cl₂ (2% - 4%) to give pure alcohol **4D** as a clear oil. The erythro selectivity was > 50:1 as judged by ¹H NMR spectroscopy. The product was determined to be 87% ee by formation of the Mosher ester: IR (film): 3435, 2861, 1454, 1363, 1099 cm⁻¹; ¹H NMR (CDCl₃, 400 MHz) δ 7.34 (5 H, m), 5.80 (1 H, m), 5.09 (1 H, dd, *J* = 1.6, 8.3 Hz), 5.04 (1 H, d, *J* = 1.6 Hz), 4.52 (2 H, s), 3.51 (2 H, t, *J* = 5.8 Hz), 3.47 (1 H, m), 2.27 (2 H, m), 1.73 (3 H, m), 1.42

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(1 H, m), 1.04 (3 H, d, $J = 6.9$ Hz); ^{13}C NMR (CDCl_3 , 100 MHz) δ 141.1, 138.2, 128.3, 127.6, 127.5, 115.0, 74.5, 72.9, 70.4, 43.7, 31.3, 26.5, 14.6.

EXAMPLE 42

TBS ether 5D: Alcohol 4D (5.00 g, 21.4 mmol) was dissolved in CH_2Cl_2 (150 mL) and 2,6-lutidine (9.97 mL, 85.6 mmol) was added. The mixture was cooled to 0°C and TBSOTf (9.83 mL, 42.8 mmol) was slowly added. The reaction was then warmed to rt. After 1 h, the reaction was poured into Et_2O (300 mL) and washed once with 1 N HCl (50 mL), once with sat NaHCO_3 (50 mL), once with brine (30 mL) and dried over anhydrous MgSO_4 . Purification by flash chromatography on silica gel eluting with hexanes/diethyl ether (97:3) gave 6.33 g (85%) of pure olefin 5D as a clear oil: IR (film): 1472, 1361, 1255, 1097, 1068 cm^{-1} ; ^1H NMR (CDCl_3 , 400 MHz) δ 7.30 (5 H, m), 5.81 (1 H, m), 4.97 (1 H, dd, $J = 1.4, 4.8$ Hz), 4.94 (1 H, d, $J = 1.1$ Hz), 3.51 (1 H, q, $J = 5.1$ Hz), 3.41 (2 H, dt, $J = 2.1, 6.6$ Hz), 2.27 (1 H, q, $J = 5.5$ Hz), 1.68 (1 h, m), 1.55 (1 H, m), 1.41 (2 H, m), 0.93 (3 H, d, $J = 6.9$ Hz), 0.85 (9 H, s), -0.01 (6 H, s); ^{13}C NMR (CDCl_3 , 100 MHz) δ 141.2, 138.6, 128.3, 127.6, 127.4, 113.9, 75.6, 72.7, 70.6, 42.7, 30.1, 25.9, 25.4, 18.1, 15.1, -4.3, -4.4.

EXAMPLE 43

Aldehyde 6D: The olefin 5 (4.00 g, 11.49 mmol) was dissolved in 1:1 $\text{MeOH}/\text{CH}_2\text{Cl}_2$ (100 mL). Pyridine (4.0 mL) was then added and the mixture cooled to -78°C . Ozone was then bubbled through the reaction for 10 minutes before the color turned light blue in color. Oxygen was then bubbled through the reaction for 10 min. Dimethyl sulfide (4.0 mL) was then added and the reaction slowly warmed to rt. The reaction was stirred overnight and then the volatiles were removed in vacuo. Purification by flash chromatography on silica gel eluting with hexanes/ethyl acetate (9:1) gave 3.31 g (82%) of the aldehyde 6D as a clear oil: IR (film): 2856, 1727, 1475, 1361, 1253, 1102 cm^{-1} ; ^1H NMR (CDCl_3 , 400 MHz) δ 9.76 (1 H, s), 7.33 (5 H, m), 4.50 (2 H, s), 4.11 (1 H, m), 3.47 (2 H, m), 2.46 (1 H, m), 1.50-1.70 (4 H, band), 1.05 (3 H, d, $J = 7.0$ Hz), 0.86 (9 H, s), 0.06 (3 H, s), 0.03 (3 H, s); ^{13}C NMR (CDCl_3 , 100 MHz) δ 204.8, 138.3, 128.2, 127.4, 127.3, 72.7, 71.7, 69.9, 51.1, 31.1, 25.9, 25.6, 17.8, 7.5, -4.4, -4.8.

EXAMPLE 44

Dianion addition product 7D: The *tert*-butyl isobutyrylacetate (0.653 g, 3.51 mmol) was added to a suspension of NaH (60% in mineral oil, 0.188 g, 4.69 mmol) in THF (50 mL) at rt. After 10 min, the mixture was cooled to 0°C . After an additional 10 min, *n*-BuLi (1.6 M in hexanes, 2.20 mL, 3.52 mmol) was slowly added. After 30 min, the aldehyde 6D (1.03 g, 2.93 mmol) was added neat. After 10 min, the reaction was quenched with H_2O (10 mL) and extracted with Et_2O (2 x 75 mL). The combined organics were washed once with brine (30 mL) and dried over anhydrous MgSO_4 . The crude reaction mixture contained a 15:1 ratio of diastereomers at C5. Purification by flash chromatography on silica gel eluting with

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hexanes/ethyl acetate (9:1 → 7:1) gave 0.723 g (47%) of the desired alcohol 7D as a clear oil: IR (film): 3531, 2953, 1739, 1702, 1367, 1255, 1153 cm^{-1} ; ^1H NMR (CDCl_3 , 400 MHz) δ 7.33 (5 H, m), 4.49 (2 H, s), 3.75 (1 H, d, J = 2.6 Hz), 3.71 (1 H, m), 3.62 (1 H, d, J = 16.0 Hz), 3.53 (1 H, d, J = 16.0 Hz), 3.44 (2 H, t, J = 5.1 Hz), 2.70 (1 H, d, J = 2.6 Hz), 1.83 (1 H, m), 1.55 (4 H, m), 1.46 (9 H, s), 1.17 (3 H, s), 1.11 (3 H, s), 0.89 (9 H, s), 0.82 (3 H, d, J = 7.0 Hz), 0.09 (6 H, s); ^{13}C NMR (CDCl_3 , 100 MHz) δ 208.9, 167.3, 138.4, 128.3, 127.6, 127.5, 81.3, 79.5, 78.7, 72.8, 70.1, 52.4, 47.6, 35.8, 30.6, 28.2, 25.9, 25.8, 22.6, 20.5, 17.9, 7.05, -4.0, -4.5.

EXAMPLE 45

10 Directed reduction: To a solution of tetramethylammonium triacetoxymethylborohydride (1.54 g, 5.88 mmol) in acetonitrile (4.0 mL) was added anhydrous AcOH (4.0 mL). The mixture was stirred at rt for 30 min before cooling to -10°C . A solution of the ester 7D (0.200 g, 0.39 mmol) in acetonitrile (1.0 mL) was added to the reaction and it was stirred at -10°C for 20 h. The reaction was quenched with 1N sodium-potassium tartrate (10 mL) and stirred at rt for 10 min. The solution was then poured into sat NaHCO_3 (25 mL) and neutralized by the addition of solid Na_2CO_3 . The mixture was then extracted with EtOAc (3 x 30 mL) and the organics were washed with brine (20 mL) and dried over anhydrous MgSO_4 . Purification by flash chromatography on silica gel eluting with hexanes/ethyl acetate (4:1) gave 0.100 g (50%) of the diol as 10:1 ratio of diastereomeric alcohols.

EXAMPLE 46

20 Monoprotection of the diol: The diol (1.76 g, 3.31 mmol) was dissolved in CH_2Cl_2 (100 mL) and cooled to 0°C . 2,6-lutidine (12.2 mL, 9.92 mmol) was added followed by TBSOTf (1.14 mL, 4.96 mmol) and the reaction slowly warmed to rt. After 1 h, the reaction was poured into Et_2O (300 mL) and washed once with 1N HCl (50 mL), once with sat NaHCO_3 (50 mL), once with brine (30 mL) and dried over anhydrous MgSO_4 . Purification by flash chromatography on silica gel eluting with hexanes/ethyl acetate (20:1 → 15:1) gave 2.03 g (95%) of the alcohol 8D as a clear oil, which was used as a mixture of diastereomers.

EXAMPLE 47

30 C5 Ketone formation: The alcohol 8D (2.03 g, 3.14 mmol) was dissolved in CH_2Cl_2 (50 mL) and Dess-Martin periodinane (2.66 g, 6.28 mmol) was added. After 2 h, a 1:1 mixture of sat'd NaHCO_3 /sat $\text{Na}_2\text{S}_2\text{O}_3$ (20 mL) was added. After 10 min, the mixture was poured into Et_2O (300 mL) and the organic layer was washed with brine (30 mL) and dried over anhydrous MgSO_4 . Purification by flash chromatography on silica gel eluting with hexanes/ethyl acetate (15:1) gave 1.85 g (91%) of the ketone (benzyl ether) as a clear oil, which was used as a mixture of diastereomers.

EXAMPLE 48

Debenzylation: The ketone (benzyl ether) (1.85 g, 2.87 mmol) was dissolved in EtOH (50

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- mL), and $\text{Pd}(\text{OH})_2$ (0.5 g) was added. The mixture was then stirred under an atmosphere of H_2 . After 3 h, the reaction was purged with N_2 and then filtered through a pad of celite rinsing with CHCl_3 (100 mL). Purification by flash chromatography on silica gel eluting with ethyl acetate in hexanes (12% - 15%) gave 1.43 g (90%) of the diastereomeric alcohols as a clear oil. The C3 diastereomers were separated by flash chromatography on TLC-grade SiO_2 eluting with ethyl acetate in hexanes (15%):
- Alpha isomer: IR (film): 3447, 1732, 1695, 1254, 1156 cm^{-1} ; ^1H NMR (CDCl_3 , 400 MHz) δ 4.24 (1 H, dd, $J = 3.6, 5.8$ Hz), 3.83 (1 H, m), 3.53 (1 H, m), 3.06 (1 H, t, $J = 7.1$ Hz), 2.36 (1 H, dd, $J = 3.6, 17.2$ Hz), 2.12 (1 H, dd, $J = 3.9, 17.2$ Hz), 1.68 (1 H, t, $J = 5.4$ Hz), 1.54 (2 H, m), 1.41 (1 H, m), 1.37 (9 H, s), 1.31 (1 H, m), 1.16 (3 H, s), 1.02 (3 H, s), 0.99 (3 H, d, $J = 6.8$ Hz), 0.84 (9 H, s), 0.81 (9 H, s), 0.05 (3 H, s), 0.01 (6 H, s), -0.01 (3 H, s); ^{13}C NMR (CDCl_3 , 100 MHz) δ 217.7, 171.3, 80.57, 73.5, 73.1, 63.0, 53.4, 26.8, 41.2, 32.1, 28.1, 28.0, 26.0, 25.9, 23.1, 19.8, 18.1 (overlapping), 15.3, -4.0, -4.3 (overlapping), -4.8.
- Beta isomer: IR (film): 3442, 2857, 1732, 1700, 1472, 1368, 1255 cm^{-1} ; ^1H NMR (CDCl_3 , 400 MHz) δ 4.45 (1 H, t, $J = 5.3$ Hz), 3.86 (1 H, m), 3.52 (2 H, q, $J = 5.9$ Hz), 3.01 (1 H, m), 2.28 (1 H, dd, $J = 4.3, 17.1$ Hz), 2.16 (1 H, dd, $J = 5.5, 17.1$ Hz), 1.67 (1 H, t, $J = 5.6$ Hz), 1.56 (2 H, m), 1.44 (1 H, m), 1.37 (9 H, s), 1.34 (1 H, m), 1.13 (3 H, s), 0.97 (3 H, d, $J = 7.4$ Hz), 0.96 (3 H, s), 0.83 (9 H, s), 0.79 (9 H, s), 0.01 (3 H, s), 0.00 (6 H, s), -0.07 (3 H, s); ^{13}C NMR (CDCl_3 , 100 MHz) δ 217.1, 171.2, 80.6, 73.5, 72.1, 62.9, 63.9, 46.4, 41.2, 32.0, 28.1, 28.0, 26.0, 25.9, 21.5, 19.5, 18.2, 18.1, 15.8, -4.0, -4.3, -4.4, -4.7.

EXAMPLE 49

- Aldehyde formation: DMSO (0.177 mL, 2.50 mmol) was added to a mixture of oxalyl chloride (0.11 mL, 1.25 mmol) in CH_2Cl_2 (15 mL) at -78°C . After 10 min, the alcohol (0.531 g, 0.96 mmol) was added in CH_2Cl_2 (4 mL). After 20 min, TEA (0.697 mL, 5.00 mmol) was added to the reaction followed by warming to rt. The reaction was then poured into H_2O (50 mL) and extracted with Et_2O (3 x 50 mL). The organics were washed once with H_2O (30 mL), once with brine (30 mL) and dried over anhydrous MgSO_4 . The aldehyde was used in crude form.

EXAMPLE 50

- Wittig olefination to give 9D: NaHMDS (1.0 M soln in THF, 1.54 mL, 1.54 mmol) was added to a suspension of methyl triphenylphosphonium bromide (0.690 g, 1.92 mmol) in THF (20 mL) at 0°C . After 1 h, the crude aldehyde (0.96 mmol) was added in THF (5 mL). After 15 min at 0°C , H_2O (0.1 mL) was added and the reaction poured into hexanes (50 mL). This was filtered through a plug of silica gel eluting with hexanes/ Et_2O (9:1, 150 mL). The crude olefin 9D was further purified by flash chromatography on silica gel eluting with ethyl acetate in hexanes (5%) to give 0.437 g (83% for two steps) of the olefin 9D as a clear oil: IR (film): 2857, 1732, 1695, 1472, 1368, 1255, 1156 cm^{-1} ; ^1H NMR (CDCl_3 , 400 MHz) δ 5.72 (1 H,

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m), 4.91 (2 H, m), 4.25 (1 H, dd, $J = 3.9, 5.4$ Hz), 3.81 (1 H, m), 3.05 (1 H, m), 2.38 (1 H, dd, $J = 7.9, 17.2$ Hz), 2.12 (1 H, dd, $J = 6.6, 17.2$ Hz), 2.04 (2 H, q, $J = 7.5$ Hz), 1.47 (1 H, m), 1.39 (9 H, s), 1.34 (1 H, m), 1.20 (3 H, s), 1.00 (3 H, s), 3.00 (3 H, d, $J = 6.7$ Hz), 0.85 (9 H, s), 0.83 (9 H, s), 0.07 (3 H, s), 0.00 (6 H, s), -0.05 (3 H, s); ^{13}C NMR (CDCl_3 , 100 MHz) δ 217.5, 172.1, 137.9, 114.0, 80.4, 74.0, 73.0, 53.0, 46.9, 41.3, 35.1, 29.0, 28.1, 26.0, 25.9, 22.8, 20.2, 18.2 (overlapping), 14.9, -4.1, -4.2, -4.3, -4.8.

EXAMPLE 51

TBS ester 10D: The olefin 9D (0.420 g, 0.76 mmol) was dissolved in CH_2Cl_2 (15 mL) and treated successively with 2,6-lutidine (1.33 mL, 11.4 mmol) and TBSOTf (1.32 mL, 5.73 mmol). After 7 h, the reaction was poured into Et_2O (100 mL) and washed successively with 0.2N HCl (25 mL), brine (20 mL) and dried over anhydrous MgSO_4 . The residue was purified by flash chromatography on a short pad of silica gel with fast elution with hexanes/ethyl acetate (20:1) to give the TBS ester 10D as a clear oil. The purification must be done quickly to avoid hydrolysis of the silyl ester: IR (film): 2930, 1721, 1695, 1472, 1254, 1091 cm^{-1} ; ^1H NMR (CDCl_3 , 400 MHz) δ 5.73 (1 H, m), 4.91 (2 H, m), 4.25 (1 H, dd, $J = 3.8, 5.4$ Hz), 3.80 (1 H, q, $J = 6.8$ Hz), 3.06 (1 H, m), 2.50 (1 H, dd, $J = 3.7, 17.3$ Hz), 2.19 (1 H, dd, $J = 5.7, 17.3$ Hz), 2.04 (2 H, dd, $J = 7.6, 15.3$ Hz), 1.49 (1 H, m), 1.36 (1 H, m), 1.21 (3 H, s), 1.00 (3 H, d, $J = 6.8$ Hz), 0.88 (9 H, s), 0.85 (9 H, s), 0.83 (9 H, s), 0.22 (3 H, s), 0.22 (3 H, s), 0.21 (3 H, s), 0.06 (3 H, s), 0.01 (6 H, s), -0.05 (3 H, s); ^{13}C NMR (CDCl_3 , 100 MHz) δ 217.3, 172.3, 138.5, 114.4, 74.5, 73.0, 53.2, 46.9, 41.8, 35.1, 29.0, 26.0, 25.7, 25.5, 22.8, 20.4, 18.2, 18.1, 17.5, 14.9, -2.9, -4.0, -4.2, -4.3, -4.8, -4.9.

EXAMPLE 52

Suzuki coupling: The acetate acid 13D was purified by flash chromatography on silica gel eluting with hexanes/ethyl acetate (7:1 \rightarrow 4:1). This was further purified by preparative-TLC eluting with hexanes/ethyl acetate (2:1) to remove unreacted vinyl iodide 12D from the acetate acid 13D. Isolated yield of the acid was 0.297 g (62% based on 90% purity with borane residues).

EXAMPLE 53

Hydrolysis of acetate acid 13D: The acetate 13D (0.220 g, 0.297 mmol) was dissolved in $\text{MeOH}/\text{H}_2\text{O}$ (2:1, 15 mL) and K_2CO_3 (0.300 g) was added. After 3 h, the reaction was diluted with sat NH_4Cl (20 mL) and extracted with CHCl_3 (5 x 20 mL). The hydroxy-acid 14D was purified by flash chromatography on silica gel eluting with hexanes/ethyl acetate (4:1 \rightarrow 2:1) to give 0.146 g (70%) of the pure hydroxy acid 14D. IR (film): 3510-2400, 1712, 1694, 1471, 1254, 1093 cm^{-1} ; ^1H NMR (CDCl_3 , 400 MHz) δ 6.96 (1 H, s), 6.66 (1 H, s), 5.55 (1 H, m), 5.38 (1 H, m), 4.38 (1 H, dd, $J = 3.4, 6.1$ Hz), 4.19 (1 H, t, $J = 7.5$ Hz), 3.84 (1 H, m), 3.05 (1 H, t, $J = 7.0$ Hz), 2.72 (3 H, s), 2.49 (1 H, dd, $J = 3.2, 16.4$ Hz), 2.42 (2 H, m), 2.33 (1 H, dd, $J = 6.2, 16.4$ Hz), 2.07 (2 H, m), 2.02 (3 H, s), 1.33 (4 H, m), 1.19 (3 H, s), 1.14 (3 H, s),

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1.06 (3 H, d, $J = 6.7$ Hz), 0.89 (9 H, s), 0.88 (9 H, s), 0.11 (3 H, s), 0.07 (3 H, s), 0.04 (6 H, s); ^{13}C NMR (CDCl_3 , 100 MHz) δ 217.8, 176.6, 164.9, 152.5, 141.7, 132.9, 125.0, 119.0, 115.3, 73.5, 73.3, 53.4, 47.0, 40.1, 35.8, 33.2, 29.8, 27.4, 26.0, 25.9, 24.5, 19.0, 18.1, 15.2, 14.3, -4.0, -4.2, -4.2, -4.7.

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EXAMPLE 54

Macrolactonization: DCC (0.150 g, 0.725 mmol), 4-DMAP (0.078 g, 0.64 mmol) and 4-DMAP·HCl (0.110 g, 0.696 mmol) were dissolved in CHCl_3 (80 mL) at 80°C. To this refluxing solution was added by syringe pump the hydroxy acid **14D** (0.020 g, 0.029 mmol) and DMAP (0.010 g) in CHCl_3 (10 mL) over 20 h. The syringe needle was placed at the base of the condenser to ensure proper addition. After 20 h, the reaction was cooled to 50°C and AcOH (0.046 mL, 0.812 mmol) was added. After 2 h, the reaction was cooled to rt and washed with sat NaHCO_3 (30 mL), brine (30 mL) and dried over anhydrous Na_2SO_4 . The lactone **15D** was purified by flash chromatography on silica gel eluting with hexanes/ethyl acetate (20:1 – 15:1) to give 0.014 g (75%): IR (film): 2929, 1741, 1696, 1254, 1097 cm^{-1} ; ^1H NMR (CDCl_3 , 400 MHz) δ 6.95 (1 H, s), 6.55 (1 H, s), 5.48 (1 H, m), 5.37 (1 H, m), 5.16 (1 H, d, $J = 9.8$ Hz), 4.17 (1 H, d, $J = 8.3$ Hz), 4.07 (1 H, t, $J = 7.2$ Hz), 3.02 (1 H, t, $J = 7.2$ Hz), 2.77 (1 H, m), 2.70 (3 H, s), 2.64 (2 H, m), 2.29 (1 H, m), 2.15 (1 H, m), 2.12 (3 H, s), 1.92 (1 H, m), 1.71 (1 H, m), 1.44 (2 H, m), 1.26 (1 H, m), 1.17 (3 H, s), 1.12 (3 H, s), 1.11 (3 H, d, $J = 7.0$ Hz), 0.91 (9 H, s), 0.85 (9 H, s), 0.09 (3 H, s), 0.06 (6 H, s), -0.04 (3 H, s); ^{13}C NMR (CDCl_3 , 100 MHz) δ 215.2, 171.9, 164.5, 152.5, 138.0, 133.5, 123.8, 120.0, 116.7, 79.4, 76.2, 72.5, 53.5, 47.4, 39.9, 34.5, 31.9, 31.5, 30.2, 27.7, 26.1, 25.9, 24.1, 23.8, 23.1, 22.6, 19.2, 18.5, 18.2, 16.3, 14.9, 14.1, -3.7, -4.2, -4.7, -5.2.

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EXAMPLE 55

Desmethyldesoxyepothilone A (16D): To the lactone **15D** (0.038 g, 0.056 mmol) in THF (2.0 mL) was added HF-pyridine (1.0 mL). After 2 h, the reaction was poured into sat NaHCO_3 (30 mL) and extracted with CHCl_3 (5 x 20 mL). The organics were dried over Na_2SO_4 . The crude diol **16D** was purified by flash chromatography on silica gel eluting with hexanes/ethyl acetate (3:1 – 2:1) to give 0.023 g (89%): IR (film): 3501, 2933, 1734, 1684, 1290, 1248, 1045 cm^{-1} ; ^1H NMR (CDCl_3 , 400 MHz) δ 6.95 (1 H, s), 6.59 (1 H, s), 5.40 (2 H, m), 5.23 (1 H, dd, $J = 1.4, 9.5$ Hz), 4.38 (1 H, bd, $J = 11.1$ Hz), 3.78 (1 H, t, $J = 6.9$ Hz), 3.59 (1 H, bs), 3.47 (1 H, s), 2.99 (1 H, q, $J = 7.0$ Hz), 2.68 (3 H, s), 2.66 (1 H, m), 2.46 (1 H, dd, $J = 11.4, 14.4$ Hz), 2.26 (1 H, dd, $J = 2.2, 14.4$ Hz), 2.22 (1 H, m), 2.06 (3 H, s), 1.96 (1 H, m), 1.49 (3 H, m), 1.35 (3 H, m), 1.30 (3 H, s), 1.15 (3 H, d, $J = 6.9$ Hz), 1.06 (3 H, s); ^{13}C NMR (CDCl_3 , 100 MHz) δ 221.5, 170.3, 165.1, 151.8, 139.1, 132.8, 125.2, 119.1, 115.5, 78.4, 72.5, 70.8, 53.8, 42.7, 39.6, 32.3, 31.8, 28.3, 26.8, 24.8, 23.1, 19.0, 17.2, 16.0, 11.1.

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EXAMPLE 56

Epoxide formation: Diol **16D** (0.008 g, 0.017 mmol) was dissolved in CH_2Cl_2 (1.0 mL) and

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cooled to -60°C . Dimethyldioxirane (0.06 M, 0.570 mL, 0.0034 mmol) was then slowly added. The reaction temperature was slowly warmed to -25°C . After 2 h at -25°C , the volatiles were removed from the reaction at -25°C under vacuum. The resulting residue was purified by flash chromatography on silica gel eluting with MeOH in CH_2Cl_2 (1% \rightarrow 2%) to give a 1.6:1 mixture of *cis*-epoxides **3D** and the diastereomeric *cis*-epoxide (0.0058 g, 74%). The diastereomeric epoxides were separated by preparative-TLC eluting with hexanes/ethyl acetate (1:1) after 3 elutions to give pure diastereomers:

Beta epoxide **3D**: IR (film): 3458, 2928, 1737, 1685, 1456, 1261, 1150, 1043, 1014 cm^{-1} ; ^1H NMR (CD_2Cl_2 , 500 MHz) δ 7.01 (1 H, s), 6.56 (1 H, s), 5.35 (1 H, dd, $J = 2.3, 9.6$ Hz), 4.30 (1 H, dd, $J = 3.0, 5.7$ Hz), 3.85 (1 H, m), 3.81 (1 H, d, $J = 5.7$ Hz), 3.42 (1 H, d, $J = 2.0$ Hz), 3.03 (1 H, q, $J = 6.8$ Hz), 2.97 (1 H, m), 2.88 (1 H, m), 2.67 (3 H, s), 2.46 (1 H, dd, $J = 9.0, 14.5$ Hz), 2.33 (1 H, dd, $J = 2.6, 14.5$ Hz), 2.13 (1 H, dt, $J = 3.0, 15.0$ Hz), 2.08 (3 H, s), 1.82 (1 H, m), 1.52 (6 H, m), 1.41 (1 H, m), 1.33 (3 H, s), 1.21 (4 H, m), 1.12 (3 H, d, $J = 7.0$ Hz), 1.06 (3 H, s); ^{13}C NMR (CD_2Cl_2 , 125 MHz) δ 221.9, 170.6, 165.6, 152.2, 138.3, 120.2, 116.6, 77.3, 73.4, 69.9, 57.7, 55.3, 43.7, 39.7, 32.6, 32.0, 29.8, 27.2, 25.7, 24.7, 22.5, 19.2, 19.0, 15.6, 15.6, 11.5;

Alpha epoxide: IR (film): 3439, 2918, 1735, 1684, 1455, 1262, 1048, 1014 cm^{-1} ; ^1H NMR (CD_2Cl_2 , 500 MHz) δ 7.02 (1 H, s), 6.56 (1 H, s), 5.62 (1 H, d, $J = 8.1$ Hz), 4.33 (1 H, dd, $J = 2.7, 11.0$ Hz), 3.85 (1 H, t, $J = 5.9$ Hz), 3.27 (1 H, d, $J = 5.3$ Hz), 3.11 (1 H, m), 3.07 (1 H, d, $J = 7.0$ Hz), 3.04 (1 H, s), 2.87 (1 H, m), 2.68 (3 H, s), 2.46 (1 H, dd, $J = 11.1, 14.1$ Hz), 2.35 (1 H, dd, $J = 2.3, 14.1$ Hz), 2.11 (3 H, s), 2.06 (1 H, ddd, $J = 1.9, 4.5, 15.1$ Hz), 1.87 (1 H, m), 1.52 (6 H, m), 1.38 (2 H, m), 1.29 (3 H, s), 1.08 (3 H, d, $J = 6.9$ Hz), 1.03 (3 H, s); ^{13}C NMR (CD_2Cl_2 , 125 MHz) δ 222.1, 170.2, 165.3, 152.5, 137.6, 119.7, 116.7, 76.7, 72.9, 70.6, 57.1, 55.1, 44.7, 40.0, 32.1, 31.4, 30.0, 26.6, 25.5, 24.7, 21.3, 19.3, 18.7, 15.7, 11.5.

EXAMPLE 57

Experimental Data for C-12 Hydroxy Epothilone Analogs

Propyl hydroxy compound 43: ^1H NMR (CDCl_3 , 400 MHz) δ 6.96 (1 H, s), 6.59 (1 H, s), 5.16-5.23 (2 H, band), 4.28 (1 H, m), 3.72 (1 H, m), 3.63 (2 H, t, $J = 6.3$ Hz), 3.17 (1 H, dq, $J = 2.2, 0.5$ Hz), 3.02 (1 H, s), 2.70 (3 H, s), 2.65 (2 H, m), 2.46 (1 H, dd, $J = 10.9, 14.6$ Hz), 2.29 (2 H, m), 1.98-2.09 (6 H, band), 1.60-1.91 (6 H, band), 1.35 (3 H, s), 1.33 (3 H, s), 1.18 (3 H, d, $J = 6.8$ Hz), 1.07 (3 H, s), 1.01 (3 H, d, $J = 7.1$ Hz); ^{13}C NMR (CDCl_3 , 100 MHz) δ 220.69, 170.29, 165.00, 151.81, 141.63, 138.93, 120.64, 118.81, 115.52, 78.53, 77.23, 73.93, 71.85, 62.26, 53.63, 41.57, 39.54, 37.98, 32.33, 32.14, 31.54, 30.75, 29.67, 25.27, 22.89, 18.92, 17.67, 15.98, 15.74, 13.28; MS m/z 536.2, calc 535.29.

Hydroxy methyl compound 46: ^1H NMR (CDCl_3 , 400 MHz) δ 6.97 (1 H, s), 6.63 (1 H, s), 5.43

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(1 H, dd, $J = 5.7, 9.1$ Hz), 5.24 (1 H, d, $J = 7.4$ Hz), 4.31 (1 H, d, $J = 9.7$ Hz), 4.05 (2 H, dd, $J = 7.3, 31.0$ Hz), 3.87 (1 H, bs), 3.69 (1 H, bs), 3.17 (1 H, dd, $J = 2.0, 6.9$ Hz), 3.03 (1 H, s), 2.69 (3 H, s), 2.63 (1 H, m), 2.45 (1 H, dd, $J = 11.2, 14.6$ Hz), 2.37 (1 H, m), 2.25 (2 H, m), 2.11 (1 H, m), 2.05 (3 H, s), 1.78 (1 H, m), 1.70 (1 H, m), 1.35 (3 H, s), 1.34 (2 H, m), 1.29 (1 H, m), 1.18 (3 H, d, $J = 6.8$ Hz), 1.06 (3 H, s), 1.00 (3 H, d, $J = 7.0$ Hz); ^{13}C NMR (CDCl_3 , 100 MHz) δ 220.70, 170.16, 165.02, 151.63, 141.56, 138.41, 121.33, 118.65, 115.33, 77.74, 77.25, 74.11, 71.37, 65.75, 53.86, 41.52, 39.52, 37.98, 31.46, 27.70, 25.10, 22.86, 18.74, 17.20, 16.17, 15.63, 13.41.

EXAMPLE 58

10 4,4-Dimethyl-3,5-dioxoheptanoate, tert-butyl ester 47. t-Butyl 4-methyl-3-oxo-4-methylpentanoate (22.5 g, 121 mmol) was added dropwise in 20 mL of dry THF to a slurry of NaH (6.29 g, 60% dispersion in mineral oil, 157.2 mmol) in 500 mL of dry THF. The reaction mixture was stirred at 0 °C for 30 min and then the cold bath was cooled to -50 °C. Freshly distilled propionyl chloride (12.3 g, 133.0 mmol) was added rapidly (neat) via syringe to the
15 cold solution. The reaction was monitored by TLC and the cold bath was maintained below -30 °C until the reaction was complete. After 1 hr, the reaction was quenched by pouring into a solution of saturated aqueous NH_4Cl and subjected to an aqueous workup. Flash column chromatography with 2% EtOAc/hexanes afforded the desired tricarbonyl 42 (16.4 g, 67.8 mmol) in 56% yield; ^1H NMR (400 MHz, CDCl_3): δ 12.43 (s, 0.20H), 5.07 (s, 0.20H), 3.36
20 (s, 1.6H), 2.47 (q, $J = 7.13$ Hz, 2H), 1.44 (s, 9H), 1.35 (s, 6H), 1.03 (t, $J = 7.18$ Hz, 3H); ^{13}C NMR (100 MHz, CDCl_3): δ 209.7, 202.9, 166.1, 81.91, 62.53, 43.34, 31.67, 27.82 (3), 21.03 (2), 7.82; IR (neat) 3411.8, 1742.6, 1718.5, 1702.0, 1644.2, 1460.6, 1156.1 cm^{-1} .

4,4-Dimethyl-5-oxo-3-triethylsilyloxy-2-heptenoate, tert-butyl ester 48. The ester 47 (5.79 g, 23.9 mmol) in THF was added to a suspension of NaH (60% in mineral oil, 1.24 g, 31.1 mmol) in THF (200 mL) at 0 °C. After 20 min, the reaction was cooled to -50 °C and TESOTf (5.95 mL, 26.32 mmol) was added. After an additional 20 min, the reaction was poured into saturated aqueous NaHCO_3 (300 mL). This mixture was extracted with Et_2O (2 x 200 mL) and the combined organic layers were dried over anhydrous MgSO_4 . The resulting oil was
25 purified by flash column chromatography on SiO_2 eluting with Et_2O /hexanes (1:20 to 1:15) to give 6.65 g (78%) of the desired enol ether 48 as a clear oil; ^1H NMR (400 MHz, CDCl_3): δ 5.16 (s, 1H), 2.48 (q, $J = 7.2$ Hz, 2H), 1.45 (s, 9H), 1.24 (s, 6H), 1.02 (t, $J = 7.2$ Hz, 3H), 0.95 (t, $J = 8.1$ Hz, 9H), 0.74 (q, $J = 8.1$ Hz, 6H); ^{13}C NMR (100 MHz, CDCl_3): δ 211.2, 169.4, 165.1, 97.77, 78.93, 55.54, 30.33, 28.21, 22.94, 8.15, 6.78, 6.02; IR (neat) 1712, 1619,
30 1384, 1243, 1150 cm^{-1} .

EXAMPLE 59

(6R,7R,8S)-7-Hydroxy-5-oxo-4,4,6,8-tetramethyl-3-triethylsilyloxy-2,10-undecadienoate.

- tert-butyl ester 49. The keto enol ether **48** (7.80 g, 22.0 mmol) in 175 mL of dry THF was cooled to -30 °C in a cold bath (CO₂(s)/CH₃CN) and then, a cooled solution of LDA (27.2 mmol, 0.90 M in THF) was added dropwise via syringe over 5 min. Immediately after the addition of the keto enol ether, the reaction vessel was placed in a -120 °C cold bath (N₂(liq)/pentane) and the reaction mixture was stirred for 10 min. Then, the aldehyde (2.0 g, 20.0 mmol) was added via syringe in 1 mL of dry THF. The reaction was complete after 30 min and was quenched by pouring into a solution of saturated aqueous NaHCO₃. The desired aldol product **49** (6.0 g, 13.2 mmol) was isolated in 60% yield (yield of the major product of a 5.5:1 mixture of diastereomers, epimeric at C-8) after flash column chromatography with 6-8% Et₂O/hexanes; (major diastereomer, higher R_f): ¹H NMR (400 MHz, CDCl₃): δ 5.78 (m, 1H), 5.22 (m, 1H), 5.05 (m, 2H), 3.37 (m, 2H), 3.18 (q, J = 7.08 Hz, 1H), 2.52 (m, 1H), 1.85 (dt, J = 14.0, 8.37 Hz, 1H), 1.62 (m, 1H), 1.55 (s, 3H), 1.46 (s, 9H), 1.22 (s, 3H), 1.25 (s, 3H), 1.04 (d, J = 6.90 Hz, 3H), 0.95 (t, J = 7.94 Hz, 6H), 0.76 (q, J = 8.26 Hz, 9H); ¹³C NMR (100 MHz, CDCl₃): δ 217.8, 168.1, 164.6, 137.1, 116.2, 99.03, 79.21, 74.82, 56.74, 40.65, 37.39, 35.06, 28.24, 22.53, 22.29, 14.77, 10.54, 6.95, 6.04; (minor diastereomer, lower R_f) ¹H NMR (400 MHz, CDCl₃): δ 5.73 (m, 1H), 5.23 (s, 1H), 5.02 (m, 2H), 3.43 (d, J = 8.74 Hz, 1H), 3.21 (m, 2H), 2.06 (m, 1H), 1.84 (m, 1H), 1.62 (m, 1H), 1.55 (s, 3H), 1.46 (s, 9H), 1.27 (s, 3H), 1.24 (s, 3H), 1.06 (d, J = 6.91 Hz, 3H), 0.96 (t, J = 8.06 Hz, 9H), 0.77 (q, J = 7.53 Hz, 6H); ¹³C NMR (100 MHz, CDCl₃): δ 217.8, 168.5, 165.0, 136.8, 116.8, 99.46, 79.62, 75.47, 57.17, 41.43, 37.86, 35.58, 30.70, 28.66, 28.31, 22.90, 22.74, 16.53, 11.77, 7.37, 6.44.

EXAMPLE 60

- (6R,7R,8S)-7-Trichloroethoxyethylcarbonate-3,5-dioxo-4,4,6,8-tetramethyl-10-undecenoate, tert-butyl ester 50. The alcohol **49** (1.61 g, 3.55 mmol) was dissolved in 20 mL of dry CH₂Cl₂ and cooled to 0 °C in an ice bath. Then, pyridine (1.12 g, 14.2 mmol) and trichloroethoxyethylcarbonyl chloride (TrocCl) (1.50 g, 7.10 mmol) were added via syringe in that order. The reaction was stirred at 0 °C for 5 min and then the ice bath was removed and the reaction was allowed to come to rt and stir for 30 minutes. After this period of time, TLC analysis showed the complete consumption of the starting material. The reaction mixture was cooled to 0 °C and the TES enol ether was hydrolyzed by the addition of 20 mL of 0.5 M methanolic HCl. The reaction mixture was stirred for 5 min at 0 °C and then quenched by pouring into a solution of saturated aqueous NaHCO₃. The desired tricarbonyl **50** (1.54 g, 3.01 mmol) was isolated after an aqueous workup and flash column chromatography with 7-9% Et₂O/hexanes; ¹H NMR (400 MHz, CDCl₃): δ 12.63 (s, 0.25H), 5.70 (m, 1H), 5.15 (s, 0.25H), 5.08-4.88 (m, 2H), 4.91 (dd, J = 6.60, 5.01 Hz, 0.30H), 4.78 (m, 1H), 4.77 (dd, J = 7.86, 3.58 Hz, 0.70H), 4.72 (dd, J = 11.8, 9.66 Hz, 1H), 3.48 (d, J = 16.2 Hz, 0.75H), 3.42 (d, J = 16.2 Hz, 0.75H), 3.36 (m, 0.30H), 3.30 (m, 0.70H), 1.88 (m, 2H), 1.50 (s, 3H), 1.46 (s, 9H), 1.39 (s, 3H), 1.12 (d, J = 6.88 Hz, 0.70H), 1.10 (d, J = 6.88 Hz, 1.3H), 0.93 (d, J =

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6.63 Hz, 1.3H), 0.88 (d, $J = 6.86$ Hz, 0.70H); ^{13}C NMR (100 MHz, CDCl_3): δ 210.5, 209.5, 203.16, 178.3, 172.6, 166.2, 154.1, 135.9, 135.6, 117.2, 116.9, 94.69, 94.56, 90.69, 82.68, 81.98, 81.65, 81.53, 63.58, 54.34, 46.56, 41.99, 41.62, 36.41, 35.84, 34.49, 34.44, 31.56, 28.23 (3), 27.94 (3), 22.62, 22.08, 21.56, 20.80, 15.95, 15.58, 14.09, 13.02, 12.98, 11.35; IR (neat) 1757.9, 1718.9, 1700.2, 1642.2, 1620.7, 1250.6, 1156.3 cm^{-1} .

EXAMPLE 61

TBS vinyl iodide 51. n-BuLi (1.6 M in hexanes, 7.69 mL, 12.3 mmol) was added to a suspension of ethyl triphenylphosphonium iodide (5.15 g, 12.3 mmol) in THF (50 mL) at 25 °C. After 20 min, the clear red solution was transferred dropwise via syringe to a vigorously stirred solution of I_2 (3.12 g, 12.3 mmol) in THF (100 mL) at -78 °C. The resulting pale yellow suspension was stirred rapidly and warmed to 20 °C. Then, NaHMDS (1.0 M soln in THF, 12.3 mL, 12.3 mmol) was added dropwise via syringe. During the addition of the NaHMDS, the reaction mixture changed from a yellow-orange slurry and to bright red solution. The TBS aldehyde (D.-S. Su et al., *Angew.Chem.Int.Ed.Engl.*, **1997**, 36, 757; 2.00 g, 6.15 mmol) was then added in THF. After 30 min, the reaction mixture was poured into hexanes (100 mL) and H_2O (0.5 mL) was added. The solution was then passed through a plug of SiO_2 eluting with 2:1 hexanes/ Et_2O . The iodide was purified by flash chromatography on SiO_2 eluting with hexanes/ethyl acetate (20:1 to 15:1) to give the vinyl iodide **51** (1.46 g, 55%) as a yellow oil: ^1H NMR (400 MHz, CDCl_3): δ 6.95 (s, 1H), 6.50 (s, 1H), 5.45 (dt, $J = 1.5, 6.8$ Hz, 1H), 4.22 (t, $J = 6.4$ Hz, 1H), 2.73 (s, 3H), 2.48 (s, 3H), 2.39 (m, 2H), 2.02 (s, 3H), 0.90 (s, 9H), 0.06 (3, s), 0.02 (3, s); ^{13}C NMR (100 MHz, CDCl_3): δ 164.86, 153.46, 142.17, 132.54, 119.23, 115.68, 102.79, 77.70, 44.40, 39.09, 26.35, 19.65, 18.63, 14.54, -4.59, -4.84; IR (neat) 2928, 1470, 1252, 1068 cm^{-1} .

Post-Suzuki, C-15 Hydroxy Tricarbonyl 52. 9-BBN (0.5 M soln in THF, 6.68 mL, 3.34 mmol) was added over a 45 min period to a solution of the olefin **50** (1.43 g, 2.78 mmol) in THF (15 mL) at 25 °C. After 2 h, TLC analysis revealed the complete consumption of the starting olefin. In a separate flask, containing the vinyl iodide **51** (1.20 g, 2.80 mmol) and DMF (20 mL), were added successively and with vigorous stirring: Cs_2CO_3 (1.82 g, 5.60 mmol), $\text{Pd}(\text{dppf})_2\text{Cl}_2$ (0.454 g, 0.56 mmol), AsPh_3 (0.171 g, 0.56 mmol) and H_2O (1.82 mL, 0.1 mmol). Then the borane solution, prepared above, was added rapidly to the vigorously stirred solution containing the vinyl iodide. After 2 h, the reaction was complete and the reaction mixture was poured into Et_2O (300 mL) and washed with H_2O (3 x 200 mL), brine (1 x 50 mL) and dried over anhydrous MgSO_4 . This crude product was purified by flash column chromatography on SiO_2 eluting with hexanes/ethyl acetate (18:1 to 13:1 to 10:1) to afford the TBS protected coupled product as an impure mixture which was taken on to the next step.

The crude TBS protected coupled product (~ 2.78 mmol) was dissolved in 0.36 N HCl

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- in MeOH (30 mL) at 25 °C. After 3.5 h, the mixture was poured into a solution of saturated aqueous NaHCO₃ and extracted with CHCl₃ (4 x 60 mL). The combined organic layers were washed once with brine (50 mL) and dried over anhydrous Na₂SO₄. The diol was purified by flash column chromatography on SiO₂ eluting with hexanes/ethyl acetate (4:1 to 3:1 to 2:1) to give the pure product **52** as a clear oil (0.910 g, 46% for two steps): ¹H NMR (400 MHz, CDCl₃): δ 6.96 (s, 1H), 6.56 (s, 1H), 5.16 (t, J = 6.9 Hz, 1H), 4.83 (d, J = 11.9 Hz, 1H), 4.75 (dd, J = 3.4, 8.0 Hz, 1H), 4.70 (d, J = 11.9 Hz, 1H), 4.14 (t, J = 6.4 Hz, 1H), 3.45 (q, J = 13.2 Hz, 2H), 3.32 (m, 1H), 2.72 (s, 3H), 2.32 (t, J = 6.5 Hz, 2H), 2.04 (s, 3H), 2.01 (m, 2H), 1.74 (m, 2H), 1.69 (s, 3H), 1.45 (s, 9H), 1.38 (s, 6H), 1.09 (d, J = 6.9 Hz, 3H), 0.93 (d, J = 6.9 Hz, 3H); ¹³C NMR (100 MHz, CDCl₃): δ 209.51, 203.04, 166.15, 164.39, 154.14, 152.72, 141.71, 138.24, 120.70, 118.76, 115.28, 94.54, 81.85, 77.31, 76.57, 63.41, 54.16, 46.47, 41.48, 34.56, 33.95, 31.98, 31.53, 27.85, 24.85, 23.45, 21.47, 20.75, 19.04, 15.60, 14.33, 11.35; IR (neat) 3546, 3395, 1756, 1717, 1699, 1644, 1621, 1506, 1456, 1251 cm⁻¹.

EXAMPLE 62

- Novori C-3/C-15 Diol Product 53.** The diketone **52** (0.900 g, 1.27 mmol) was dissolved in 0.12 N HCl in MeOH (10 mL) at 25 °C. The RuBINAP catalyst (0.018 M in THF, 1.0 mL, 0.018 mmol) was then added and the mixture transferred to a Parr apparatus. The vessel was purged with H₂ for 5 min and then pressurized to 1200 psi. After 12 h at 25 °C, the reaction was returned to atmospheric pressure and poured into a saturated solution of NaHCO₃. This mixture was extracted with CHCl₃ (4 x 50 mL) and the combined organic layers were dried over anhydrous Na₂SO₄. The product was purified by flash column chromatography on silica gel eluting with hexanes/ethyl acetate (4:1 to 2:1) to give 0.75 g (81%) of the hydroxy ester **53** as a white foam; ¹H NMR (400 MHz, CDCl₃): δ 6.94 (s, 1H), 6.55 (s, 1H), 5.15 (t, J = 6.9 Hz, 1H), 4.85 (t, J = 5.3 Hz, 1H), 4.81 (d, J = 12.0 Hz, 1H), 4.71 (d, J = 12.0 Hz, 1H), 4.12 (m, 2H), 3.43 (m, 2H), 2.70 (s, 3H), 2.37 (dd, J = 2.2, 6.2 Hz, 1H), 2.30 (t, J = 6.7 Hz, 2H), 2.24 (dd, J = 10.6, 16.2 Hz, 1H), 2.03 (s, 3H), 1.99 (m, 2H), 1.68 (s, 3H), 1.44 (s, 9H), 1.18 (s, 3H), 1.16 (s, 3H), 1.09 (d, J = 6.8 Hz, 3H), 0.94 (d, J = 6.8 Hz, 3H); ¹³C NMR (100 MHz, CDCl₃): δ 215.95, 172.39, 164.39, 154.21, 152.74, 141.70, 138.33, 120.59, 118.77, 115.27, 94.64, 82.98, 81.26, 76.51, 72.78, 51.82, 41.40, 37.36, 34.66, 33.96, 32.08, 31.10, 30.20, 27.96, 25.06, 23.45, 21.73, 21.07, 19.17, 19.01, 16.12, 15.16, 14.33, 12.17; IR (neat) 3434.0, 1757.5, 1704.5, 1249.9, 1152.8 cm⁻¹.

EXAMPLE 63

- C-3/C-15 Bis(TES) Carboxylic Acid 54.** 2,6-Lutidine (0.48 g, 4.5 mmol) and TESOTf (0.59 g, 2.25 mmol) were added successively to a cooled solution of the diol **53** (164 mg, 0.225 mmol) in CH₂Cl₂ (2.5 mL) at -78 °C. The reaction mixture was stirred at -78 °C for 5 min and then warmed to rt. The reaction was stirred at rt for 6 hr and then quenched with saturated aqueous NH₄Cl and subjected to an aqueous workup. The crude product was concentrated in vacuo

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and subjected directly to the next set of reaction conditions; ^1H NMR (400 MHz, CDCl_3): δ 6.96 (s, 1H), 6.66 (s, 1H), 5.04 (t, J = 6.93 Hz, 1H), 4.90 (d, J = 12.0 Hz, 1H), 4.77 (dd, J = 7.99, 3.21 Hz, 1H), 4.66 (d, J = 12.0 Hz, 1H), 4.46 (m, 1H), 4.10 (dq, J = 12.3, 7.11 Hz, 2H), 3.42 (m, 1H), 2.70 (s, 3H), 2.60 (dd, J = 16.7, 2.34 Hz, 1H), 2.34 (dd, J = 16.7, 7.94 Hz, 1H), 2.27 (dd, J = 14.0, 6.97 Hz, 1H), 2.18 (m, 1H), 2.09 (m, 1H), 2.04 (s, 1H), 1.95 (s, 3H), 1.82 (m, 2H), 1.61 (s, 3H), 1.44 (m, 2H), 1.27-1.22 (m, 4H), 1.14 (d, J = 8.45 Hz, 3H), 1.11 (d, J = 6.81 Hz, 2H), 1.04 (d, J = 6.88 Hz, 2H), 1.15-1.01 (m, 2H), 0.94 (t, J = 7.92 Hz, 18H), 0.65-0.57 (m, 12H); ^{13}C NMR (100 MHz, CDCl_3): δ 215.11, 175.34, 165.00, 154.14, 152.80, 142.60, 136.84, 121.31, 118.79, 114.60, 94.77, 81.60, 79.06, 76.64, 73.87, 54.19, 41.18, 39.56, 35.09, 34.52, 32.29, 31.95, 24.76, 23.62, 22.55, 18.95, 18.64, 15.87, 13.69, 11.33, 6.94, 6.83, 5.07, 4.76; IR (neat) 3100-2390, 1756.8, 1708.8, 1459.3, 1250.6, 816.1 cm^{-1} .

EXAMPLE 64

C-15 Hydroxy Acid for Macrolactonization 55. The crude bis(triethylsilyl)ether **54**, prepared above, was dissolved in 5 mL of dry THF and then cooled to 0 °C. Then, 1 mL of 0.12 M HCl/MeOH was added. The reaction mixture was stirred at 0 °C for 20 min and then checked for completion. TLC analysis at this time revealed the complete consumption of starting material. The reaction was quenched by pouring into a solution of saturated aqueous NaHCO_3 and subjected to an aqueous workup. Flash column chromatography with 25 to 30:1 $\text{CHCl}_3/\text{MeOH}$ afforded the desired carboxylic acid **55** in 77% yield; ^1H NMR (400 MHz, CDCl_3): δ 6.96 (s, 1H), 6.69 (t, s), 5.11 (t, J = 6.9 Hz, 1H), 4.91 (d, J = 12.0 Hz, 1H), 4.71 (dd, J = 3.1, 8.2 Hz, 1H), 4.64 (d, J = 12.0 Hz, 1H), 4.42 (d, J = 5.9 Hz, 1H), 4.10 (m, 1H), 3.43 (m, 1H), 2.71 (s, 3H), 2.57 (dd, J = 2.1, 10.5 Hz, 1H), 2.25 (m, 3H), 2.11 (m, 1H), 1.98 (s, 3H), 1.95 (m, 2H), 1.72 (m, 1), 1.67 (s, 3H), 1.45 (m, 2H), 1.16 (s, 3H), 1.13 (s, 3H), 1.09 (d, J = 6.7 Hz, 3H), 0.99 (d, J = 6.7 Hz, 3H), 0.95 (t, J = 7.9 Hz, 9H), 0.64 (dq, J = 2.3, 7.9 Hz, 6H); ^{13}C NMR (100 MHz, CDCl_3): δ 215.11, 176.00 (165.10, 154.18, 152.35, 142.24, 138.55, 120.74, 118.21, 115.02, 94.76, 81.91, 76.86, 76.63, 73.95, 54.08, 41.28, 39.64, 34.73, 34.16, 32.02, 31.67, 24.71, 23.41, 22.49, 19.17, 18.62, 15.71, 14.86, 11.20, 6.93, 5.05); IR (neat) 3400-2390, 1755.9, 1703.8, 1250.4, 735.4 cm^{-1} .

EXAMPLE 65

C-3 Triethylsilyl/C-7 Trichloroethoxyethylcarbonate Macrolactonization Product 56. Triethylamine (155 mg, 1.53 mmol) and 2,4,6-trichlorobenzoyl chloride (312 mg, 1.28 mmol) were added to a solution of the hydroxy acid **55** (198 mg, 0.256 mmol) in 3.6 mL of dry THF. The reaction mixture was stirred for 0.25 h at rt and then diluted with 45 mL of dry toluene. The resultant solution was added slowly dropwise, via syringe pump, over 3 hr to a stirred solution of DMAP (328 mg, 2.68 mmol) in 145 mL of dry toluene. After the addition of the substrate was complete, the reaction was stirred for an additional 0.5 h and then taken up in an equal volume of Et_2O and washed with 1N HCl (1x), saturated aqueous NaHCO_3 (1x), and brine

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(1x). The organic layer was dried over MgSO_4 and concentrated in vacuo. Flash column chromatography of the crude product with 10% EtOAc/hexanes afforded the desired macrolactone (153 mg, 0.20 mmol) in 78% yield; ^1H NMR (400 MHz, CDCl_3): δ 6.96 (s, 1H), 6.53 (s, 1H), 5.20 (m, 2H), 5.04 (d, J = 10.2 Hz, 1H), 4.84 (d, J = 12.0 Hz, 1H), 4.78 (d, J = 12.0 Hz, 1H), 4.07 (m, 1H), 3.32 (m, 1H), 2.86-2.63 (m, 3H), 2.70 (s, 3H), 2.48 (m, 1H), 2.11 (s, 3H), 2.04 (dd, J = 6.17, 14.7 Hz, 1H), 1.73 (m, 4H), 1.66 (s, 3H), 1.25 (m, 2H), 1.19 (s, 3H), 1.15 (s, 3H), 1.12 (d, J = 6.68 Hz, 3H), 1.01 (d, J = 6.83 Hz, 3H), 0.89 (t, J = 8.00 Hz, 9H), 0.58 (q, J = 7.83 Hz, 6H); ^{13}C NMR (100 MHz, CDCl_3): δ 212.75, 170.66, 164.62, 154.60, 152.52, 140.29, 138.44, 119.81, 119.38, 116.28, 94.84, 86.44, 80.14, 76.59, 76.10, 53.55, 45.89, 39.23, 35.47, 32.39, 31.69, 31.57, 31.16, 29.68, 27.41, 25.00, 23.44, 22.94, 19.23, 18.66, 16.28, 14.83, 6.89, 5.22; IR (neat) 1760.5, 1742.6, 1698.0, 1378.8, 1246.2, 1106.0, 729.8 cm^{-1} .

EXAMPLE 66

Sml₂ Mediated Deprotection of Troc Group 57. Samarium metal (0.334 g, 2.22 mmol) and iodine (0.51 g, 2.0 mmol) in 25 mL of dry, deoxygenated THF were stirred together vigorously for 2.5 hr at ambient temperature. During this period of time, the reaction mixture progressed from a dark orange to an olive green to deep blue color. The resultant deep blue solution of Sml₂ was used directly in the following reaction. Sml₂ (25 mL of a 0.08 M stock solution, 2.0 mmol) was added rapidly via syringe to a stirred solution of the macrolactone 57 (200 mg, 0.26 mmol) and a catalytic amount of NiI_2 (10 mg) in 10 mL of dry THF at -78 °C. The resultant deep blue solution was maintained at -78 °C with continued vigorous stirring for 2.5 hr. TLC analysis at this time revealed the complete consumption of the starting material and formation of a single, lower R_f product. The reaction mixture was quenched with saturated aqueous NaHCO_3 and subjected to an aqueous workup. Flash column chromatography with 25% EtOAc/hexanes afforded the desired alcohol 57 (143 mg, 0.24 mmol) in 91% yield; ^1H NMR (400 MHz, CDCl_3): δ 6.95 (s, 1H), 6.54 (s, 1H), 5.15 (m, 1H), 5.05 (d, J = 10.15 Hz, 1H), 4.08 (dd, J = 10.1, 2.66 Hz, 1H), 3.87 (m, 1H), 3.01 (s, 1H), 3.06 (m, 1H), 2.83-2.65 (m, 3H), 2.70 (s, 3H), 2.44 (m, 1H), 2.10 (s, 3H), 2.07 (m, 1H), 1.83 (m, 1H), 1.77 (m, 1H), 1.71 (m, 1H), 1.64 (s, 3H), 1.60 (s, 1H), 1.37 (m, 1H), 1.31 (m, 1H), 1.20 (m, 1H), 1.15 (s, 3H), 1.14 (m, 5H), 1.02 (d, J = 7.02 Hz, 3H), 0.89 (t, J = 7.97 Hz, 9H), 0.64-0.52 (m, 6H); ^{13}C NMR (100 MHz, CDCl_3): δ 218.34, 170.73, 164.59, 152.46, 139.07, 138.49, 120.48, 119.54, 116.00, 79.31, 75.81, 73.48, 53.62, 42.98, 39.48, 39.01, 32.85, 32.41, 31.20, 26.12, 24.26, 22.01, 22.46, 19.18, 16.44, 15.30, 13.99, 6.98 (3), 5.27 (3); IR (neat) 3524.0, 1740.3, 1693.4, 1457.2, 1378.4, 733.2 cm^{-1} .

EXAMPLE 67

Desoxyepothilone B 2C. The TES protected alcohol 57 (143 mg, 0.24 mmol) was dissolved in 2 mL of dry THF in a plastic reaction vessel and cooled to 0 °C in an ice bath. The

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resultant solution was treated with 1 mL of HF-pyridine. The reaction mixture was stirred for 80 min at 0 °C and then quenched by pouring into a saturated aqueous solution of NaHCO₃. An aqueous workup followed by flash column chromatography with 10% EtOAc/hexanes afforded desoxyepothilone B (112 mg, 0.23 mmol) in 95% yield. The resultant product exhibited a ¹H NMR spectrum identical to that of authentic desoxyepothilone B.

Total Synthesis of Desoxyepothilone B

EXAMPLE 68

tert-Butyl 4-methyl-3-oxopentanoate (1E). Meldrum's acid (80 g, 555 mmol) was dissolved in 600 mL of CH₂Cl₂ and cooled to 0 °C. Freshly distilled pyridine (87.8 g, 1.11 mol) was added to the CH₂Cl₂ solution and then *iso*-butyryl chloride (65.0 g, 610.5 mmol) was added to the mixture via a pressure equalizing addition funnel. The reaction was stirred at 0 °C for 1 hr and then warmed to rt and stirred for 2 hr. Then, the reaction was quenched with water (200 mL) and washed with 0.5 M HCl (x2), water (x1), and brine (x1). The organic layer was dried over MgSO₄ and concentrated *in vacuo*. The crude product was azeotropically dried with benzene (250 mL), and then dissolved in 200 mL of benzene and 200 mL of *tert*-butanol was added. The resultant reaction was heated at reflux for 4 hr. After this period, the volatiles were removed *in vacuo* and the product then distilled on the high vacuum pump (bp 62-63 °C, 0.1 mm Hg). The desired β-keto ester 1E was obtained (58.6 g, 315.5 mmol) in 57% yield as a clear, colorless, light oil.

EXAMPLE 69

tert-Butyl 4,4-dimethyl-3,5-dioxoheptanoate (2E). β-Keto ester 1E (55.0 g, 295.3 mmol) was added dropwise in 50 mL of dry THF to a slurry of NaH (9.7 g, 60% dispersion in mineral oil, 383.9 mmol) in 1.15 L of dry THF. The reaction mixture was stirred at 0 °C for 30 min and then the cold bath was cooled to -50 °C. Propionyl chloride (27.3 g, 295.3 mmol) was added rapidly (neat) by syringe to the cold solution. The reaction was monitored by TLC and the cold bath was maintained below -30 °C until the reaction was complete. After 1 hr, the reaction was quenched by pouring into a solution of saturated aqueous NH₄Cl and subjected to an aqueous workup. The aqueous layer was extracted with Et₂O (x2, 200 mL). Flash column chromatography with 2% EtOAc/hexanes afforded the desired tricarbonyl 2E (50.7 g, 209.6 mmol) in 71% yield; ¹H NMR (400 MHz, CDCl₃): δ 12.43 (s, 0.20H), 5.07 (s, 0.20H), 3.36 (s, 1.6H), 2.47 (q, *J* = 7.13 Hz, 2H), 1.44 (s, 9H), 1.35 (s, 6H), 1.03 (t, *J* = 7.18 Hz, 3H); ¹³C NMR (100 MHz, CDCl₃): δ 209.7, 202.9, 166.1, 81.91, 62.53, 43.34, 31.67, 27.82 (3), 21.03 (2), 7.82; IR (neat) 3411.8, 1742.6, 1718.5, 1702.0, 1644.2, 1460.6, 1156.1 cm⁻¹.

EXAMPLE 70

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***tert*-Butyl-4,4-dimethyl-3-methoxy-5-oxo-2-heptenoate (3E).**

Trimethylsilyldiazomethane (TMSCHN₂, 46.2 mL of a 2.0 M solution in THF, 92.4 mmol) was added by syringe to a stirred solution of the tricarbonyl (16.0 g, 66.0 mmol) and diisopropylethylamine (Hunig's base, 16.1 mL, 92.4 mmol) in 330 mL of a 9:1 solution of acetonitrile:methanol at rt. The resultant reaction mixture was stirred at rt for 18-20 hr. The reaction mixture was then quenched with saturated aqueous NaHCO₃ and the enol ether extracted with Et₂O (x3, 50 mL). The combined organic layers were washed with brine and then dried of MgSO₄, filtered and concentrated *in vacuo*. Flash column chromatography of the crude product (2% EtOAc/hexanes) afforded the desired enol ether 3E (12.5 g, 48.4 mmol) in 74% yield; ¹H NMR (400 MHz, CDCl₃): δ 5.18 (s, 1H), 3.88 (s, 3H), 2.45 (q, *J* = 7.33 Hz, 2H), 1.48 (s, 9H), 1.25 (s, 6H), 1.02 (t, *J* = 7.21 Hz, 3H).

EXAMPLE 71

(6*R*,7*R*,8*S*)-7-Hydroxy-5-oxo-4,4,6,8-tetramethyl-3-triethoxysilyloxy-2,10-undecadienoate, *tert*-butyl ester (6E). The keto enol ether 3E (8.0 g, 31.3 mmol) in 750 mL of dry THF was cooled to -30 °C in a cold bath (CO₂(s)/CH₃CN) and then a solution of LDA (37.5 mmol, 0.90 M in THF) was added dropwise via syringe over 10 min. The reaction mixture was stirred at -30 to -33 °C for 20 min. Then the reaction vessel was placed in a -120 °C cold bath (N₂(liq)/pentane) and the reaction mixture was stirred for 10 min. Finally the aldehyde 5 (3.6 g, 36.7 mmol; aldehyde 5E was readily prepared according to the procedure outlined in: Lin, N.-H., *et al.*, *J. Am. Chem. Soc.* **1996**, *118*, 9062.) was added via syringe in 5 mL of CH₂Cl₂. The reaction was complete after 10 min and was quenched by pouring into a solution of saturated aqueous NH₄Cl. The desired aldol product 6E (5.2 g, 14.7 mmol) was isolated in 47% yield (yield of the major product of a 5.5:1 mixture of diastereomers, epimeric at C-8) after flash column chromatography with 6-5% EtOAc/hexanes; (major diastereomer, high R_f): ¹H NMR (400 MHz, CDCl₃): δ 5.78 (m, 1H), 5.18 (s, 1H), 4.98 (m, 2H), 3.90 (s, 3H), 3.37 (m, 1H), 3.35 (s, 1H), 3.35 (s, 1H), 3.12 (q, *J* = 7.74 Hz, 1H), 2.53 (m, 1H), 1.87 (dt, *J* = 13.8, 8.47 Hz, 1H), 1.61 (m, 1H), 1.55 (s, 1H), 1.48 (s, 9H), 1.28 (s, 3H), 1.27 (s, 3H), 1.05 (d, *J* = 6.91 Hz, 3H), .079 (d, *J* = 6.76 Hz, 3H); ¹³C NMR (100 MHz, CDCl₃): δ 217.7, 171.2, 164.8, 137.0, 116.3, 97.29, 80.22, 74.67, 62.17, 56.05, 41.05, 37.31, 34.99, 28.13, 22.69, 22.67, 15.00, 10.44; (minor diastereomer, low R_f): ¹H NMR (400 MHz, CDCl₃): δ 5.76 (m, 1H), 5.19 (s, 1H), 5.06 (m, 2H), 1.48 (s, 3H), 3.41 (m, 1H), 3.17 (m, 1H), 3.12 (m, 1H), 2.11 (m, 1H), 1.86 (m, 1H), 1.63 (m, 1H), 1.48 (s, 9H), 1.28 (s, 3H), 1.27 (s, 3H), 1.07 (s, *J* = 6.91 Hz, 3H), 0.99 (d, *J* = 6.64 Hz, 3H).

EXAMPLE 72

(6*R*,7*R*,8*S*)-7-(2,2,2-Trichloroethoxycarbonate)-5-oxo-4,4,6,8-tetramethyl-3-triethylsilyloxy-2,10-undecadienoate, *tert*-butyl ester. Alcohol 6E (5.2 g, 14.7 mmol) was dissolved in 70 mL of dry CH₂Cl₂ and cooled to 0 °C in an ice bath. Then, pyridine (4.65 g, 58.8 mmol)

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and trichloroethoxyethylcarbonoyl chloride (TrocCl) (6.23 g, 29.4 mmol) were added by syringe in that order. The reaction was stirred at 0 °C for 5 min and then the ice bath was removed and the reaction was allowed to come to rt and stir for 30 minutes. After this period of time, TLC analysis showed the complete consumption of the starting material. The reaction mixture was quenched by pouring it into a solution of saturated aqueous NaHCO₃. Flash column chromatography with 3% EtOAc/hexanes through a short plug of silica gel afforded the desired enol ether which was subjected immediately to hydrolysis; ¹H NMR (400 MHz, CDCl₃): δ 5.71 (m, 1H), 5.21 (s, 1H), 5.02 (m, 2H), 4.86 (d, *J* = 11.9 Hz, 1H), 4.85 (m, 1H), 4.72 (d, *J* = 11.9 Hz, 1H), 3.91 (s, 3H), 3.25 (m, 1H), 2.26 (m, 1H), 1.87 (m, 1H), 1.81 (m, 1H), 1.48 (s, 9H), 1.31 (s, 3H), 1.26 (d, 3H), 1.11 (d, *J* = 6.85 Hz, 3H), 0.91 (d, *J* = 6.64 Hz, 3H).

EXAMPLE 73

(6*R*,7*R*,8*S*)-7-Trichloroethoxyethylcarbonate-3,5-dioxo-4,4,6,8-tetramethyl-10-undecenoate, *tert*-butyl ester (7E). The Troc-protected enol ether (as above) was dissolved in acetone and treated with 300 mg (catalytic) of *p*-TsOH at rt for 5-6 hrs. The reaction was monitored by TLC and after complete consumption of the starting enol ether was apparent, the reaction mixture was quenched with saturated aqueous NaHCO₃. The desired tricarbonyl 7E (6.8 g, 12.8 mmol), 87% (2 steps) was isolated after an aqueous workup and flash column chromatography with 7-9% EtOAc/hexanes; ¹H NMR (400 MHz, CDCl₃): δ 12.63 (s, 0.25H), 5.70 (m, 1H), 5.15 (s, 0.25H), 5.08-4.88 (m, 2H), 4.91 (dd, *J* = 6.60, 5.01 Hz, 0.30H), 4.78 (m, 1H), 4.77 (dd, *J* = 7.86, 3.58 Hz, 0.70H), 4.72 (dd, *J* = 11.8, 9.66 Hz, 1H), 3.48 (d, *J* = 16.2 Hz, 0.75H), 3.42 (d, *J* = 16.2 Hz, 0.75H), 3.36 (m, 0.30H), 3.30 (m, 0.70H), 1.88 (m, 2H), 1.50 (s, 3H), 1.46 (s, 9H), 1.39 (s, 3H), 1.12 (d, *J* = 6.88 Hz, 0.70H), 1.10 (d, *J* = 6.88 Hz, 1.3H), 0.93 (d, *J* = 6.63 Hz, 1.3H), 0.88 (d, *J* = 6.86 Hz, 0.70H); ¹³C NMR (100 MHz, CDCl₃): δ 210.5, 209.5, 203.16, 178.3, 172.6, 166.2, 154.1, 135.9, 135.6, 117.2, 116.9, 94.69, 94.56, 90.69, 82.68, 81.98, 81.65, 81.53, 63.58, 54.34, 46.56, 41.99, 41.62, 36.41, 35.84, 34.49, 34.44, 31.56, 28.23 (3), 27.94 (3), 22.62, 22.08, 21.56, 20.80, 15.95, 15.58, 14.09, 13.02, 12.98, 11.35; IR (neat) 1757.98, 1718.9, 1700.2, 1642.2, 1620.7, 1250.6, 1156.3 cm⁻¹.

EXAMPLE 74

Allylic Alcohol (16E). A mixture of (*S*)-(-)-1,1'-bi-2-naphthol (1.37 g, 4.8 mmol), Ti(O-*i*-Pr)₄ (1.36 g, 4.8 mmol), and 4 Å sieves (11 g) in CH₂Cl₂ (300 mL) was heated at reflux for 1 h. The mixture was cooled to rt and aldehyde 15E (8.0 g, 47.9 mmol; prepared according to the procedure outlined in an earlier Danishefsky synthesis of the epothilones: Meng, D.; Sorensen, E. J.; Bertinato, P.; Danishefsky, S. J. *J. Org. Chem.* 1996, 61, 7998) was added. After 10 min, the suspension was cooled to -78 °C, and allyl tri-*n*-butyltin (20.9 g, 67.1 mmol) was added. The reaction mixture was stirred for 10 min at -78 °C and then placed in

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a 20 °C freezer for 70 h. Saturated aqueous NaHCO₃ solution (2 mL) was added, and the mixture was stirred for 1 h, poured over Na₂SO₄, and then filtered through a pad of MgSO₄ and celite. The crude material was purified by flash chromatography with EtOAc/hexanes (5%→10%→15%→20%→25%→30%, two column volumes each) to give alcohol **16E** as a yellow oil (6.0 g, 88.0 mmol) in 60% yield; $[\alpha]_D = -15.9$ (c. 4.9, CHCl₃); IR (film) 3360, 1641, 1509, 1434, 1188, 1017, 914 cm⁻¹; ¹H NMR (500 MHz, CDCl₃, 25 °C) δ 6.92 (s, 1 H), 6.55 (s, 1 H), 5.82 (m, 1 H), 5.13 (dd, *J* = 17.1, 1.3 Hz, 1 H), 5.09 (d, *J* = 10.2 Hz, 1 H), 4.21 (t, *J* = 6.0 Hz, 1 H), 2.76 (br s, 1 H), 2.69 (s, 3 H), 2.40 (m, 2 H), 2.02 (s, 3 H); ¹³C NMR (125 MHz, CDCl₃, 25 °C) δ 164.5, 152.6, 141.5, 134.6, 119.2, 117.6, 115.3, 76.4, 39.9, 19.0, 14.2; HRMS calcd. for C₁₁H₁₅NOS: 209.0874 found: 209.0872 (M+H).

EXAMPLE 75

TBS allylic ether (17E). Alcohol **16E** (5.70 g, 27.3 mmol) was dissolved in 50 mL of dry CH₂Cl₂ and cooled to -78 °C. Then, 2,6-lutidine (7.6 g, 70.9 mmol) and TBSOTf (9.36 g, 35.4 mmol) were added via syringe successively and in that order. The reaction mixture was stirred at this temperature for 30 minutes and then quenched by pouring the reaction mixture into saturated aqueous NaHCO₃. An aqueous workup followed by flash column chromatography with 2% EtOAc/hexanes afforded the desired TBS ether (7.37 g, 22.8 mmol) in 84% yield. The allylic alcohol, **17E**, could also be prepared according to the general procedure outlined in the following references: (a) Racherla, U. S.; Brown, H. C. *J. Org. Chem.* **1991**, 56, 401. (b) Yang, Z.; He, Y.; Vourloumis, D.; Vallberg, H.; Nicolaou, K. C. *Angew. Chem., Int. Ed. Engl.*, **1997**, 36, 166.

EXAMPLE 76

Aldehyde (18E). To a solution of TBS ether **17E** (7.37 g, 22.8 mmol) in acetone (150 mL) at 0 °C was added 6.7 g of a 60% solution of *N*-methyl-morpholine-*N*-oxide (NMO) in water (34.2 mmol), OsO₄ (0.039 M in THF, 6 mL, 0.23 mmol). The resultant mixture was stirred at 0 °C for 2 h and then quenched with saturated aqueous Na₂SO₃ solution (100 mL). The solution was poured into H₂O (100 mL) and extracted with EtOAc (8 x 50 mL). The combined organic layer was dried over MgSO₄, filtered, concentrated, and flashed through a short plug of silica gel to afford (7.8 g, 21.8 mmol) the crude diol in 96% yield.

To a solution of the crude diol (7.8 g, 21.8 mmol; the oxidation procedure described here may also be accomplished with NaIO₄ as outlined in a previous Danishefsky synthesis of the epothilones: Meng, D., et al., *J. Ann. Chem. Soc.* **1997**, 119, 10073.) in 400 mL benzene at 0 °C was added Pb(OAc)₄ (19.4 g, 43.7 mmol) and Na₂CO₃ (9.24 g, 87.2 mmol). The reaction mixture was stirred at 0 °C for 10 min and then rt for 1.5 hr. After this period of time, the reaction mixture was quenched by pouring into brine. The reaction was filtered through Celite™ and then the resultant aqueous layer was extracted with EtOAc (5 x 50 mL) dried over MgSO₄. Flash column chromatography on silica gel with 20% EtOAc/hexanes on

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a short pad of silica gave the aldehyde **18E** as a yellow oil (5.02 g, 15.5 mmol) in 71% yield.

EXAMPLE 77

TBS vinyl iodide (19E). *n*-BuLi (2.5 M in hexanes, 22.6 mL, 55.4 mmol) was added to a suspension of ethyl triphenylphosphonium iodide (23.2 g, 55.4 mmol) in THF (100 mL) at 25°C. After 30 min, the clear red solution was transferred dropwise by syringe to a vigorously stirred solution of I₂ (14.1 g, 55.4 mmol) in THF (1100 mL) at -78°C. After addition of the Wittig reagent was completed, the resulting pale yellow suspension was stirred rapidly and warmed to 20° C. Then, NaHMDS (1.0 M soln in THF, 55.4 mL, 55.4 mmol) was added dropwise by syringe. During the addition of the NaHMDS, the reaction mixture changed from a yellow-orange slurry and to bright red solution. Aldehyde **18E** (6.0 g, 18.5 mmol) was then added in THF. After 30 min, the reaction mixture was poured into hexanes (400 mL) and then 0.5 mL brine was added. The solution was then passed through a plug of SiO₂ eluting with 2:1 hexanes/Et₂O. The iodide was purified by flash chromatography on SiO₂ eluting with hexanes/ethyl acetate (20:1 to 15:1) to give the vinyl iodide **19E** (5.0 g, 10.2 mmol, 50%) as a yellow oil: ¹H NMR (400 MHz, CDCl₃): δ 6.95 (s, 1H), 6.50 (s, 1H), 5.45 (dt, *J* = 1.5, 6.8 Hz, 1H), 4.22 (t, *J* = 6.4 Hz, 1H), 2.73 (s, 3H), 2.48 (s, 3H), 2.39 (m, 2H), 2.02 (s, 3H), 0.90 (s, 9H), 0.06 (3, s), 0.02 (3, s); ¹³C NMR (100 MHz, CDCl₃): δ 164.86, 153.46, 142.17, 132.54, 119.23; 115.68, 102.79, 77.70, 44.40, 39.09, 26.35, 19.65, 18.63, 14.54, -4.59, -4.84; IR (neat) 2928, 1470, 1252, 1068 cm⁻¹.

EXAMPLE 78

Post-Suzuki, C-15 Hydroxy Tricarbonyl (10E). 9-BBN (0.5 M soln in THF, 14.1 mL, 7.03 mmol) was added over a 45 min period to a solution of the olefin **7E** (2.78 g, 5.41 mmol) in THF (25 mL) at 25°C. After 2 h, TLC analysis revealed the complete consumption of the starting olefin.

In a separate flask, containing the vinyl iodide **18E** (2.65 g, 5.41 mmol) and DMF (45 mL), were added successively and with vigorous stirring: Cs₂CO₃ (3.52 g, 10.82 mmol); Pd(dppf)₂Cl₂ (1.10 g, 1.35 mmol), AsPh₃ (0.41 g, 1.35 mmol) and H₂O (3.5 mL, 0.19 mol). Then the borane solution, prepared above, was added rapidly by syringe to the vigorously stirred solution containing the vinyl iodide. After 2 h, the reaction TLC analysis revealed that the reaction was complete. The reaction mixture was poured into Et₂O (3 x 200 mL), brine (1 x 50 mL) dried over anhydrous MgSO₄. This crude product was purified by flash column chromatography on SiO₂ eluting with hexanes/ethyl acetate (18:1 to 13:1 to 10:1) to afford the TBS protected coupled product **9E** as an impure mixture which was taken on to the next step without further purification.

The crude TBS protected coupled product **9E** was dissolved in 0.5 M HCl in MeOH (30 mL) at 25°C. The reaction was monitored by TLC for corruption and after 3.5 h (disappearance of starting TBS ether), the mixture was poured into a solution of saturated

aqueous NaHCO_3 and extracted with CHCl_3 (4 x 60 mL). The combined organic layers were washed once with brine (50 mL) and dried over with anhydrous MgSO_4 . The diol was purified by flash column chromatography on SiO_2 eluting with hexanes/ethyl acetate (4:1 to 3:1 to 2:1) to give the pure product **10E** as a clear oil (2.44 g, 3.35 mmol, 62% for two steps): ^1H NMR (400 MHz, CDCl_3): δ 6.96 (s, 1H), 6.56 (s, 1H), 5.16 (t, J = 6.9 Hz, 1H), 4.83 (d, J = 11.9 Hz, 1H), 4.75 (dd, J = 3.4, 8.0 Hz, 1H), 4.70 (d, J = 11.9 Hz, 1H), (t, J = 6.4 Hz, 1H), 3.45 (q, J = 13.2 Hz, 2H), 3.32 (m, 1H), 2.72 (s, 3H), 2.32 (t, J = 6.5 Hz, 2H), 2.04 (s, 3H), 2.01 (m, 2H), 1.74 (m, 2H), 1.69 (s, 3H), 1.45 (s, 9H), 1.38 (s, 6H), 1.09 (d, J = 6.9 Hz, 3H), 0.93 (d, J = 6.9 Hz, 3H); ^{13}C NMR (100 MHz CDCl_3): δ 209.51, 203.04, 166.15, 164.39, 154.14, 152.72, 141.71, 138.24, 120.70, 118.76, 115.28, 94.54, 81.85, 77.31, 76.57, 63.41, 54.16, 46.47, 41.48, 34.56, 33.95, 31.98, 31.53, 27.85, 24.85, 23.45, 21.47, 20.75, 19.04, 15.60, 14.33, 11.35; IR (neat) 3546, 3395, 1756, 1717, 1699, 1644, 1621, 1506, 1456, 1251, cm^{-1} .

EXAMPLE 79

Noyori C-3/C-15 Diol Product (11E). The diketone **10E** (1.77 g, 2.43 mmol) was dissolved in 0.12 N HCl in MeOH (21 mL, 1.3 eq) at 25°C. The (*R*)-RuBINAP catalyst (0.045 M in THF, 8.0 mL, 0.36 mmol) was then added and the mixture transferred to a Parr apparatus. The vessel was purged with H_2 for 5 min and then pressurized to 1200 psi. After 12-14 h at 25°C, the reaction was returned to atmospheric pressure and poured into a saturated solution of NaHCO_3 . This mixture was extracted with CHCl_3 (4 x 50 mL) and the combined organic layers were dried over anhydrous MgSO_4 . The product was purified by flash column chromatography on silica gel eluting with hexanes/ethyl acetate (4:1 to 2:1) to give 1.42 g (81%) of the hydroxy ester **11E** as a green foam; ^1H NMR (400 MHz, CDCl_3): δ 6.96 (s, 1H), 6.55 (s, 1H), 5.15 (t, J = 6.9 Hz, 1H), 4.85 (t, J = 5.3 Hz, 1H), 4.81 (d, J = 12.0 Hz, 1H), 4.71 (d, J = 12.0 Hz, 1H), 4.12 (m, 2H), 3.43 (m, 2H), 2.70 (s, 3H), 2.37 (dd, J = 2.2, 6.2 Hz, 1H), 2.30 (t, J = 6.7 Hz, 2H), 2.24 (dd, J = 10.6, 16.2 Hz, 1H), 2.03 (s, 3H), 1.99 (m, 2H), 1.68 (s, 3h), 1.44 (s, 9h), 1.18 (s, 3h), 1.16 (s, 3h), 1.09 (d, J = 6.8 Hz, 3H), 0.94 (d, J = 6.8 Hz, 3H); ^{13}C NMR (100 MHz CDCl_3): δ 215.95, 172.39, 164.39, 154.21, 152.74, 141.70, 138.33, 120.59, 118.77, 115.27, 94.64, 82.98, 81.26, 76.51, 72.78, 51.82, 41.40, 37.36, 34.66, 33.96, 32.08, 31.10, 30.20, 27.96, 25.06, 23.45, 21.73, 21.07, 19.17, 19.01, 16.12, 15.16, 14.33, 12.17; IR (neat) 3434.0, 1757.5, 1704.5, 1249.9, 1152.8 cm^{-1} .

C-3/C-15 Bis(TES) Carboxylic Acid. 2,6-Lutidine (2.1 g, 19.6 mmol) and TESOTf (2.6 g, 9.8 mmol) were added successively to a cooled solution of the diol **11E** (2.38, 3.26 mmol) in CH_2Cl_2 (30 mL) at -78°C. The reaction mixture was stirred at -78°C for 5 min and then warmed to rt and stirred for 1 hr. Then 2,6-lutidine (4.9 g, 45.6 mmol) and TESOTf (6.0 g, 22.8 mmol) were added successively to a -78°C cooled solution. The reaction was stirred at rt for 6 hr and then quenched with saturated aqueous NH_4Cl and subjected to an aqueous workup. The crude product was concentrated *in vacuo* and the 2,6-lutidine removed on high

vacuum pump and then subjected directly to the next set of reaction conditions; ¹H NMR (400 MHz, CDCl₃): δ 6.96 (s, 1H), 6.66 (s, 1H), 5.04 (t, *J* = 6.93 Hz, 1H), 4.90 (d, *J* = 12.0 Hz, 1H), 4.77 (dd, *J* = 7.99, 3.21 Hz, 1H), 4.66 (d, *J* = 12.0 Hz, 1H), 4.46 (m, 1H), 4.10 (dq, *J* = 12.3, 7.11 Hz, 2H), 3.42 (m, 1H), 2.70 (s, 3H), 2.60 (dd, *J* = 16.7, 2.34 Hz, 1H), 2.34 (dd, *J* = 16.7, 7.94 Hz, 1H), 2.27 (dd, *J* = 14.0, 6.97 Hz, 1H), 2.18 (m, 1H), 2.09 (m, 1H), 2.04 (s, 1H), 1.95 (s, 3H), 1.82 (m, 2H), 1.61 (s, 3H), 1.44 (m, 2H), 1.27-1.22 (m, 4H), 1.14 (d, *J* = 8.45 Hz, 3H), 1.11 (d, *J* = 6.81 Hz, 2H), 1.04 (d, *J* = 6.88 Hz, 2H), 1.15-1.01 (m, 2H), 0.94 (t, *J* = 7.92 Hz, 18H), 0.65-0.57 (m, 12H); ¹³C NMR (100 MHz, CDCl₃): δ 215.11, 175.34, 165.00, 154.14, 152.80, 142.60, 136.84, 121.31, 118.79, 114.60, 94.77, 81.60, 79.06, 76.64, 73.87, 54.19, 41.18, 39.56, 35.09, 34.52, 32.29, 31.95, 24.76, 23.62, 22.55, 18.95, 18.64, 15.87, 13.69, 11.33, 6.94, 6.83, 5.07, 4.76; IR (neat) 3100-2390, 1756.8, 1708.8, 1459.3, 1250.6, 816.1 cm⁻¹.

EXAMPLE 80

C-15 Hydroxy Acid for Macrolactonization (12E). The crude bis(triethylsilyl)ether, prepared above, was dissolved in 20 mL of dry THF and then cooled to 0 °C. Then, 6 ml of 0.12 M HCl/MeOH was added. The reaction mixture was stirred at 0 °C for 3 min and maintained at 0°C for the duration. The reaction was monitored closely by TLC analysis. Methanolic HCl (0.12 M) was added in small portions, and roughly 1.3 equivalents of 0.12 M HCl was required for the hydrolysis of the C-15 TBS ether (approximately 30-40 mL). The reaction was complete in approximately 30 min. The reaction was quenched by pouring into a solution of saturated aqueous NaHCO₃ and subjected to an aqueous workup. Flash column chromatography with 40% EtOAc/hexanes afforded the desired carboxylic acid **12E** (1.71 g, 2.20 mmol) in 67% yield; ¹H NMR (400 MHz, CDCl₃): δ 6.96 (s, 1H), 6.69 (t, s), 5.11 (t, *J* = 6.9 Hz, 1H), 4.91 (d, *J* = 12.0 Hz, 1H), 4.71 (dd, *J* = 3.1, 8.2 Hz, 1H), 4.64 (d, *J* = 12.0 Hz, 1H), 4.42 (d, *J* = 5.9 Hz, 1H), 4.10 (m, 1H), 3.43 (m, 1H), 2.71 (s, 3H), 2.57 (dd, *J* = 2.1, 10.5 Hz, 1H), 2.25 (m, 3H), 2.11 (m, 1H), 1.98 (s, 3H), 1.95 (m, 2H), 1.72 (m, 1), 1.67 (s, 3H), 1.45 (m, 2H), 1.16 (s, 3H), 1.13 (s, 3H), 1.09 (d, *J* = 6.7 Hz, 3H), 0.99 (d, *J* = 6.7 Hz, 3H), 0.95 (t, *J* = 7.9 Hz, 9H), 0.64 (dq, *J* = 2.3, 7.9 Hz, 6H); ¹³C NMR (100 MHz, CDCl₃): δ 215.11, 176.00 (165.10, 154.18, 152.35, 142.24, 138.55, 120.74, 118.21, 115.02, 94.76, 81.91, 76.86, 76.63, 73.95, 54.08, 41.28, 39.64, 34.73, 34.16, 32.02, 31.67, 24.71, 23.41, 22.49, 19.17, 18.62, 15.71, 14.86, 11.20, 6.93, 5.05); IR (neat) 3400-2390, 1755.9, 1703.8, 1250.4, 735.4 cm⁻¹.

EXAMPLE 81

C-3 Triethylsilyl/C-7 Trichloroethoxyethylcarbonate Macrolactonization Product (13E). Triethylamine (155 mg, 1.53 mmol) and 2,4,6-trichlorobenzoyl chloride (312 mg, 1.28 mmol) were added to a solution of the hydroxy acid **12E** (198 mg, 0.256 mmol) in 3.6 mL of dry THF. The reaction mixture was stirred for 15 min (and NO LONGER) at rt and then diluted

with 20 mL of dry toluene. The resultant solution was added slowly dropwise, via syringe pump, over 3 hr to a previously prepared, stirred solution of DMAP (328 mg, 2.68 mmol) in 300 mL of dry toluene. After the addition of the substrate was complete, the reaction was stirred for an additional 0.5 h and then concentrated *in vacuo*. Flash column chromatography of the crude product with 10% EtOAc/hexanes afforded the macrolactone **13E** (153 mg, 0.20 mmol) in 78% yield; ¹H NMR (400 MHz, CDCl₃): δ 6.96 (s, 1H), 6.53 (s, 1H), 5.20 (m, 2H), 5.04 (d, *J* = 10.2 Hz, 1H), 4.84 (d, *J* = 12.0 Hz, 1H), 4.78 (d, *J* = 12.0 Hz, 1H), 4.07 (m, 1H), 3.32 (m, 1H), 2.86-2.63 (m, 3H), 2.70 (s, 3H), 2.48 (m, 1H), 2.11 (s, 3H), 2.04 (dd, *J* = 6.17, 14.7 Hz, 1H), 1.73 (m, 4H), 1.66 (s, 3H), 1.25 (m, 2H), 1.19 (s, 3H), 1.15 (s, 3H), 1.12 (d, *J* = 6.68 Hz, 3H), 1.01 (d, *J* = 6.83 Hz, 3H), 0.89 (t, *J* = 8.00 Hz, 9H), 0.58 (q, *J* = 7.83 Hz, 6H); ¹³C NMR (100 MHz, CDCl₃): δ 212.75, 170.66, 164.62, 154.60, 152.52, 140.29, 138.44, 119.81, 119.38, 116.28, 94.84, 86.44, 80.14, 76.59, 76.10, 53.55, 45.89, 39.23, 35.47, 32.39, 31.69, 31.57, 31.16, 29.68, 27.41, 25.00, 23.44, 22.94, 19.23, 18.66, 16.28, 14.83, 6.89, 5.22; IR (neat) 1760.5, 1742.6, 1698.0, 1378.8, 1246.2, 1106.0, 729.8 cm⁻¹.

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EXAMPLE 82

Sml₂ Mediated Deprotection of Troc Group. Samarium metal (0.52 g, 3.43 mmol) and iodine (0.78 g, 3.09 mmol) in 40 mL of dry, deoxygenated THF were stirred together vigorously at reflux for 2.5 hr. During this period of time, the reaction mixture progressed from a dark orange to an olive green to deep blue color. The resultant deep blue solution of Sml₂ was used directly in the following reaction. A catalytic amount of Nil₂ (10 mg) was added in one portion to the vigorously stirred solution of Sml₂. The reaction mixture was stirred 5 min at rt and then cooled to -78°C in a dry ice/acetone bath. Then, the macrolactone **13E** (297 mg, 0.386 mmol), in 10 mL of dry THF, was added over 1 min to the rapidly stirred, cold solution of Sml₂/Nil₂. The resultant deep blue solution was maintained at -78°C with continued vigorous stirring for 1 hr. TLC analysis at this time revealed the complete consumption of the starting material and formation of a single, lower R_f product. The reaction mixture was quenched with saturated aqueous NaHCO₃ and subjected to an aqueous workup. Flash column chromatography with 25% EtOAc/hexanes afforded the C-7 alcohol (204 mg, 0.343 mmol) in 89% yield; ¹H NMR (400 MHz, CDCl₃): δ 6.95 (s, 1H), 6.54 (s, 1H), 5.15 (m, 1H), 5.05 (d, *J* = 10.15 Hz, 1H), 4.08 (dd, *J* = 10.1, 2.66 Hz, 1H), 3.87 (m, 1H), 3.01 (s, 1H), 3.06 (m, 1H), 2.83-2.65 (m, 3H), 2.70 (s, 3H), 2.44 (m, 1H), 2.10 (s, 3H), 2.07 (m, 1H), 1.83 (m, 1H), 1.77 (m, 1H), 1.71 (m, 1H), 1.64 (s, 3H), 1.60 (s, 1H), 1.37 (m, 1H), 1.31 (m, 1H), 1.20 (m, 1H), 1.15 (s, 3H), 1.14 (m, 5H), 1.02 (d, *J* = 7.02 Hz, 3H), 0.89 (t, *J* = 7.97 Hz, 9H), 0.64-0.52 (m, 6H); ¹³C NMR (100 MHz, CDCl₃): δ 218.34, 170.73, 164.59, 152.46, 139.07, 138.49, 120.48, 119.54, 116.00, 79.31, 75.81, 73.48, 53.62, 42.98, 39.48, 39.01, 32.85, 32.41, 31.20, 26.12, 24.26, 22.01, 22.46, 19.18, 16.44, 15.30, 13.99, 6.98 (3), 5.27 (3); IR (neat) 3524.0, 1740.3, 1693.4, 1457.2, 1378.4, 733.2 cm⁻¹.

EXAMPLE 83

Desoxyepothilone B (12E). The C-3 TES protected alcohol (204 mg, 0.343 mmol) was dissolved in 6 mL of dry THF in a plastic reaction vessel and cooled to 0 °C in an ice bath. The resultant solution was treated with 3 mL of HF-pyridine. The reaction mixture was stirred
5 for 80 min at 0°C and then quenched by pouring into a saturated aqueous solution of NaHCO₃. An aqueous workup followed by flash column chromatography with 10% EtOAc/hexanes afforded desoxyepothilone B 12E (160 mg, 0.32 mmol) in 95% yield. The resultant product exhibited a ¹H NMR spectrum identical to desoxyepothilone B prepared as described hereinabove.

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DiscussionTotal Synthesis of (-)-Epothilone A.

The first known method for preparing epothilone A (1) is provided by this invention. Carbons 9 through 11 insulate domains of chirality embracing carbons 3 through 8 on the acyl
15 side of the macrolactone, and carbons 12 through 15 on the alkyl side. Transmitting stereochemical information from one of the segments to the other is unlikely. Thus, the approach taken deals with the stereochemistry of each segment individually. In the acyl segment, this strategy required knowledge of both the relative and absolute configurations of the "polypropionate-like" network. In the alkyl segment, two possibilities emerge. In one
20 instance, the C12-C13 epoxide would be included in the construct undergoing merger with the acyl related substructure. In that case it would be necessary to secure the relative stereochemical relationship of carbons 15, 13 and 12. It was necessary to consider the possibility that the epoxide would be deleted from the alkyl-side moiety undergoing coupling. This approach would only be feasible if the epoxide could be introduced with acceptable
25 stereocontrol after closure of the macrocycle. The synthesis of compound 4, which contains most of the requisite stereochemical information required for the acyl fragment, is described above. This intermediate is prepared by a novel oxidatively induced solvolytic cleavage of the cyclopropanopyran 3. Also described above is a construct containing the alkyl side coupling partner embodying the absolute and relative stereochemistry at carbons 15, 13 and
30 12, which differs from the alternative approach set forth below.

In considering the union of the alkyl and acyl domains, several potential connection sites were available. At some point, an acylation would be required to establish an ester (or lactone) bond (see bold arrow 2). Furthermore, an aldol construction was required to fashion a C2-C3 connection. Determining the exact timing of this aldol step required study. It could
35 be considered in the context of elongating the C3-C9 construct to prepare it for acylation of the C-15 hydroxyl. Unexpectedly, it was discovered that the macrolide could be closed by an unprecedented macroaldolization. (For a previous instance of a keto aldehyde

macroaldolization, see: C.M. Hayward, et al., *J. Am. Chem. Soc.*, **1993**, *115*, 9345.) This option is implied by bold arrow 3 in Figure 1(A).

The first stage merger of the acyl and alkyl fragments (see bold arrow 1) posed a difficult synthetic hurdle. It is recognized in the art (P. Bertinato, et al., *J. Org. Chem.*, **1996**, *61*, 8000; *vide infra*) that significant resistance is encountered in attempting to accomplish bond formation between carbons 9 and 10 or between carbons 10 and 11, wherein the epoxide would be included in the alkyl coupling partner. These complications arose from unanticipated difficulties in fashioning acyl and alkyl reactants with the appropriate complementarity for merger across either of these bonds. An initial merger between carbons 11 and 12 was examined. This approach dictated deletion of the oxirane linkage from the O-alkyl coupling partner. After testing several permutations, generalized systems 5 and 6 were examined to enter the first stage coupling reaction. The former series was to be derived from intermediate 4. A *de novo* synthesis of a usable substrate corresponding to generalized system 5 would be necessary (Figure 1(B)).

The steps leading from 4 to 11 are shown in Scheme 2. Protection of the future C-7 alcohol (see compound 7) was followed by cleavage of the benzyl ether and oxidation to aldehyde 8. Elongation of the aldehyde to the terminal allyl containing fragment 10 proceeded through end ether 9 (mixture of E and Z geometrical isomers). Finally, the dithiane linkage was oxidatively cleaved under solvolytic trapping conditions, giving rise to specific coupling component 11. G. Stork; K. Zhao, *Tetrahedron Lett.* **1989**, *30*, 287.

The synthesis of the alkyl fragment started with commercially available (R)-glycidol 12 which was converted, via its THP derivative 13, to alcohol 14. After cleavage of the tetrahydropyran blocking group, the resultant alcohol was smoothly converted to the methyl ketone 15, as shown. The latter underwent an Emmons-type homologation with phosphine oxide 16. D. Meng et al., *J. Org. Chem.*, **1996**, *61*, 7998. This Emmons coupling provided a ca. 8:1 mixture of olefin stereoisomers in favor of *trans*-17. The resultant alkyne 17 was then converted, via compound 18 to Z-iodoalkene 19 (see Figure 4(A)). E.J. Corey et al., *J. Am. Chem. Soc.*, **1985**, *107*, 713.

The critical first stage coupling of the two fragments was achieved by a B-alkyl Suzuki carbon-carbon bond construction. N. Miyaura et al., *J. Am. Chem. Soc.*, **1989**, *111*, 314; N. Miyaura and A. Suzuki, *Chem. Rev.*, **1995**, *95*, 2457. Thus, hydroboration of the pre-acyl fragment 11 was accomplished by its reaction with 9-BBN. The resultant mixed borane cross-coupled to iodoolefin 19, under the conditions indicated, to give 20 in 71% yield. (Figure 4(B)) Upon cleavage of the acetal, aldehyde 21 was in hand.

The availability of 21 permitted exploration of the strategy in which the methyl group of the C-1 bound acetoxy function would serve as the nucleophilic component in a macroaldolization. Cf. C.M. Hayward et al., *supra*. Deprotonation was thereby accomplished

with potassium hexamethyldisilazide in THF at -78°C. Unexpectedly, these conditions give rise to a highly stereoselective macroaldolization, resulting in the formation of the C-3 (S)-alcohol **22**, as shown. The heavy preponderance of **22** was favored when its precursor potassium aldolate is quenched at ca. 0°C. When the aldolate was protonated at lower temperature, higher amounts of the C-3 (R) compound were detected. In fact, under some treatments, the C-3 (R) epimer predominates. It is therefore possible to generate highly favorable C-3(R):C-3(S) ratios in analytical scale quenches. In preparative scale experiments, the ratio of **22** to its C-3 epimer is 6:1.

With compound **22** in ready supply, the subgoal of obtaining desoxyepothilone (**23**) was feasible. This objective was accomplished by selective removal of the triphenylsilyl (TPS) group in **22**, followed, sequentially, by selective silylation of the C-3 alcohol, oxidation of the C-5 alcohol, and, finally, fluoride-induced cleavage of the two silyl ethers.

Examination of a model made possible by the published crystal structure of epothilone (Höfle *et al.*, *supra*), suggested that the oxirane is disposed on the convex periphery of the macrolide. Oxidation of **23** was carried out with dimethyl dioxirane under the conditions shown. The major product of this reaction was (-)epothilone A (**1**), the identity of which was established by nmr, infrared, mass spectral, optical rotation and chromatographic comparisons with authentic material. Höfle *et al.*, *supra*. In addition to epothilone A (**1**), small amounts of a diepoxide mixture, as well as traces of the diastereomeric *cis* C12-C13 monoepoxide ($\geq 20:1$) were detected.

The method of synthesis disclosed herein provides workable, practical amounts of epothilone A. More importantly, it provides routes to congeners, analogues and derivatives not available from the natural product itself.

25 Studies Toward a Synthesis of Epothilone A: Use of Hydropyran Templates For the Management of Acyclic Stereochemical Relationships.

The synthesis of an enantiomerically pure equivalent of the alkoxy segment (carbons 9-15) was carried out in model studies. The key principle involves transference of stereochemical bias from an (S)-lactaldehyde derivative to an emerging dihydropyrone. The latter, on addition of the thiazole moiety and disassembly, provides the desired acyclic fragment in enantiomerically pure form.

Various novel structural features of the epothilones make their synthesis challenging. The presence of a thiazole moiety, as well as a *cis* epoxide, and a geminal dimethyl grouping are key problems to be overcome. An intriguing feature is the array of three contiguous methylene groups which serves to insulate the two functional domains of the molecules. The need to encompass such an achiral "spacer element" actually complicates prospects for continuous chirality transfer and seems to call for a strategy of merging two stereochemically

committed substructures. The present invention provides a synthesis of compound **4A** (Figure 14), expecting that, in principle, such a structure could be converted to the epothilones themselves, and to related screening candidates.

The identification of compound **4A** as a synthetic intermediate served as an opportunity to illustrate the power of hydropyran matrices in addressing problems associated with the control of stereochemistry in acyclic intermediates. The synthesis of dihydropyrones was previously disclosed through what amounts to overall cyclocondensation of suitably active dienes and aldehydic heterodienophiles. Danishefsky, S.J. *Aldrichimica Acta*, **1986**, *19*, 59. High margins of stereoselectivity can be realized in assembling (cf. **5A** + **6A** → **7A**) such matrices (Figure 13). Moreover, the hydropyran platforms service various stereospecific reactions (see formalism **7A** → **8A**). Furthermore, the products of these reactions are amenable to ring opening schemes, resulting in the expression of acyclic fragments with defined stereochemical relationships (cf. **8A** → **9A**). Danishefsky, S. J. *Chemtracts*, **1989**, *2*, 273.

The present invention provides the application of two such routes for the synthesis of compound **4A**. Route 1, which does not *per se* involve control of the issue of absolute configuration, commences with the known aldehyde **10A**. Shafiee, A., et al., *J. Heterocyclic Chem.*, **1979**, *16*, 1563; Shafiee, A.; Shahocini, S. J. *Heterocyclic Chem.*, **1989**, *26*, 1627. Homologation, as shown, provided enal **12A**. Cyclocondensation of **12A** with the known diene (Danishefsky, S.J.; Kitahara, T. *J. Am. Chem. Soc.*, **1974**, *96*, 7807), under BF_3 catalysis, led to racemic dihydropyrone **13A**. Reduction of **13A** under Luche conditions provided compound **14A**. Luche, J.-L. *J. Am. Chem. Soc.*, **1978**, *100*, 2226. At this point it was feasible to take advantage of a previously introduced lipase methodology for resolution of glycal derivatives through enzymatically mediated kinetic resolution. Berkowitz, D.B. and Danishefsky, S.J. *Tetrahedron Lett.*, **1991**, *32*, 5497; Berkowitz, D.B.; Danishefsky, S.J.; Schulte, G.K. *J. Am. Chem. Soc.*, **1992**, *114*, 4518. Thus, carbinol **14A** was subjected to lipase 30, in the presence of isopropenyl acetate, following the prescriptions of Wong (Hsu, S.-H., et al., *Tetrahedron Lett.*, **1990**, *31*, 6403) to provide acetate **15A** in addition to the enantiomerically related free glycal **16A**. Compound **15A** was further advanced to the PMB protected system **17A**. At this juncture, it was possible to use another reaction type previously demonstrated by the present inventors. Thus, reaction of **17A** with dimethyldioxirane (Danishefsky, S.J.; Bilodeau, M.T. *Angew. Chem. Int. Ed. Engl.*, **1996**, *35*, 1381) generated an intermediate (presumably the corresponding glycal epoxide) which, upon treatment with sodium metaperiodate gave rise to aldehyde formate **18A**. Allylation of **18A** resulted in the formation of carbinol **19A** in which the formate ester had nicely survived. (For a review of allylations, see: Yamamoto, Y.; Asao, N. *Chem. Rev.* **1993**, *93*, 2207.) However, **19A** was accompanied by its *anti* stereoisomer (not shown here) [4 : 1]. Mesylation of the secondary alcohol, followed by deprotection (see **19A** → **20A**) and cyclization, as indicated,

gave compound 4A.

In this synthesis, only about half of the dihydropyrone was secured through the process of kinetic resolution. While, in theory, several of the synthetic stratagems considered contemplate use of each enantiomer of 15A to reach epothilone itself, another route was sought to allow for full enantiomeric convergence. The logic of this route is that the chirality of a "dummy" asymmetric center is communicated to the emerging pyran following previously established principles of tunable diastereoselection in the cyclocondensation reaction. (Danishefsky, *supra*) Cyclo-condensation of lactaldehyde derivative 21A (Heathcock, C.H., *et al.*, *J. Org. Chem.*, **1980**, 45, 3846) with the indicated diene, under ostensible chelation control, afforded 22A. The side chain ether could then be converted to the methyl ketone 25A as shown (see 22A → 23A → 24A → 25A). Finally, an Emmons condensation (for example, see: Lythgoe, B., *et al.*, *Tetrahedron Lett.*, **1975**, 3863; Toh, H.T.; Okamura, W.H. *J. Org. Chem.*, **1983**, 48, 1414; Baggiolini, E.G., *et al.*, *J. Org. Chem.*, **1986**, 51, 3098) of 25A with the phosphine oxide 26A was transformed to phosphine oxide 26A according to the procedure described in Toh, *supra*) as shown in Figure 15 gave rise to 27A. (The known 2-methyl-4-chloromethylthiazole (see Marzoni, G. *J. Heterocyclic Chem.*, **1986**, 23, 577.) A straightforward protecting group adjustment then afforded the previously encountered 17A. This route illustrates the concept of stereochemical imprinting through a carbon center which eventually emerges in planar form after conferring enantioselection to subsequently derived stereocenters. The use of the dihydropyrone based logic for securing the stereochemical elements of the epothilones, as well as the identification of a possible strategy for macrocyclization will be described in the following section.

Studies Toward a Synthesis of Epothilone A: Stereocontrolled

25 Assembly of the Acyl Region and Models for Macrocyclization.

Ring-forming olefin metathesis has been employed to construct 16-membered ring congeners related to epothilone A. A stereospecific synthesis of the C3-C9 sector of the acyl fragment was achieved by exploiting a novel oxidative opening of a cyclopropanated glycol.

Disclosed in the previous section is a synthesis of the "alkoxy" segment of epothilone (1) (see compound 2B, Figure 7) encompassing carbons 10 to 21. In this section the synthesis of another fragment encoding the stereochemical information of acyl section carbons 3 to 9. It was envisioned that the aldehyde center (C₃) of the formal target 3B would serve as an attachment site to a nucleophilic construct derived from compound 2B (requiring placement of a 2 carbon insert, as suggested in Figure 7), through either inter- or intramolecular means. In such a context, it would be necessary to deal independently with the stereochemistry of the secondary alcohol center eventually required at C₃. One of the interesting features of system 3B is the presence of geminal methyl groups at carbon 4 (epothilone numbering).

Again, use is made of a dihydropyran strategy to assemble a cyclic matrix corresponding, after appropriate disassembly, to a viable equivalent of system **3B**. The expectation was to enlarge upon the dihydropyran paradigm to include the synthesis of *gem*-dimethyl containing cyclic and acyclic fragments. The particular reaction type for this purpose is generalized under the heading of transformation of **4B** → **5B** (see Figure 7). Commitment as to the nature of the electrophile E is avoided. Accordingly, the question whether a reduction would or would not be necessary in going from structure type **5B** to reach the intended generalized target **3B** is not addressed.

The opening step consisted of a stereochemically tuneable version of the diene-aldehyde cyclocondensation reaction (Figure 8; Danishefsky, S.J., *Aldrichimica Acta*, **1986**, 19, 59), in this instance drawing upon chelation control in the merger of the readily available enantiomerically homogenous aldehyde **6B** with the previously known diene **7B**. Danishefsky, S.J., et al., *J. Am. Chem. Soc.* **1979**, 101, 7001. Indeed, as precedent would have it, under the influence of titanium tetrachloride there was produced substantially a single isomer shown as compound **8B**. In the usual and stereochemically reliable way (Danishefsky, S.J., *Chemtracts Org. Chem.* **1989**, 2, 273), the dihydropyrone was reduced to the corresponding glycol, **9B**. At this point, it was feasible to utilize a directed Simmons-Smith reaction for the conversion of glycol **9B** to cyclopropane **10B**. Winstein, S.; Sonnenberg, J. *J. Am. Chem. Soc.*, **1961**, 83, 3235; Dauben, W.G.; Berezin, G.H. *J. Am. Chem. Soc.*, **1963**, 85, 468; Furukawa, J., et al., *Tetrahedron*, **1968**, 24, 53; For selected examples, see Soeckman, R.K. Jr.: Charette, A.B.; Asberom, T.; Johnston, B.H. *J. Am. Chem. Soc.*, **1991**, 113, 5337; Timmers, C.M.; Leeuwenburgh, M.A.; Verheijen, J.C.; Van der Marel, G.A.; Van Boom, J.H. *Tetrahedron: Asymmetry*, **1996**, 7, 49. This compound is indeed an interesting structure in that it corresponds in one sense to a cyclopropano version of a C-glycoside. At the same time, the cyclopropane is part of a cyclopropylcarbiny alcohol system with attendant possibilities for rearrangement. Wenkert, E., et al., *J. Amer. Chem. Soc.*, **1970**, 92, 7428. It was intended to cleave the C-glycosidic bond of the cyclopropane in a fashion which would elaborate the geminal methyl groups, resulting in a solvent-derived glycoside with the desired aldehyde oxidation state at C-3 (see hypothesized transformation **4B** → **5B**, Figure 7). In early efforts, the non-oxidative version of the projected reaction (i.e. $E^+ = H^+$) could not be reduced to practice. Instead, products clearly attributable to the ring expanded system **11** were identified. For example, exposure of **10B** to acidic methanol gave rise to an epimeric mixture of seven-membered mixed-acetals, presumably through the addition of methanol to oxocarbenium ion **11B**.

However, the desired sense of cyclopropane opening, under the influence of the ring oxygen, was achieved by subjecting compound **10B** to oxidative opening with N-iodosuccinimide. (For interesting Hg(II)-induced solvolyses of cyclopropanes that are

conceptually similar to the conversion of **10B** to **12B**, see: Collum, D.B.; Still, W.C.; Mohamadi, F. *J. Amer. Chem. Soc.*, **1986**, *108*, 2094; Collum, D.B.; Mohamadi, F.; Hallock, J.S.; *J. Amer. Chem. Soc.*, **1983**, *105*, 6882. Following this precedent, a Hg(II)-induced solvolysis of cyclopropane **10B** was achieved, although this transformation proved to be less efficient than the reaction shown in Figure 8.) The intermediate iodomethyl compound, obtained as a methyl glycoside **12B**, when exposed to the action of *tri-n*-butyltinhydride gave rise to pyran **13B** containing the geminal methyl groups. Protection of this alcohol (see **13B** - **14B**), followed by cleavage of the glycosidic bond, revealed the acyclic dithiane derivative **15B** which can serve as a functional version of the hypothetical aldehyde **3B**.

Possible ways of combining fragments relating to **2B** and **3B** in a fashion to reach epothilone and congeners thereof were examined. In view of the studies of Schrock (Schrock, R.R., et al., *J. Am. Chem. Soc.*, **1990**, *112*, 3875) and Grubbs (Schwab, P. et al., *Angew. Chem. Int. Ed. Engl.*, **1995**, *34*, 2039; Grubbs, R.H.; Miller, S.J. Fu, G.C. *Acc. Chem. Res.*, **1995**, *28*, 446; Schmalz, H.-G., *Angew. Chem. Int. Ed. Engl.*, **1995**, *34*, 1833) and the disclosure of Hoveyda (Houri, A.F., et al., *J. Am. Chem. Soc.*, **1995**, *117*, 2943), wherein a complex lactam was constructed in a key intramolecular olefin macrocyclization step through a molybdenum mediated intramolecular olefin in metathesis reaction (Schrock, *supra*; Schwab, *supra*), the possibility of realizing such an approach was considered. (For other examples of ring-closing metathesis, see: Martin, S.F.; Chen, H.-J.; Courtney, A.K.; Lia, Y.; Pätzelt, M.; Ramser, M N.; Wagman, A.S. *Tetrahedron*, **1996**, *52*, 7251; Fürstner, A.; Langemann, K. *J. Org. Chem.*, **1996**, *61*, 3942.)

The matter was first examined with two model ω -unsaturated acids **16B** and **17B** which were used to acylate alcohol **2B** to provide esters **18B** and **19B**, respectively (see Figure 9). These compounds did indeed undergo olefin metathesis macrocyclization in the desired manner under the conditions shown. In the case of substrate **18B**, compound set **20B** was obtained as a mixture of E- and Z-stereoisomers [ca. 1:1]. Diimide reduction of **20B** was then conducted to provide homogeneous **22B**. The olefin metathesis reaction was also extended to compound **19B** bearing geminal methyl groups corresponding to their placement at C4 of epothilone A. Olefin metathesis occurred, this time curiously producing olefin **21B** as a single entity in 70% yield (stereochemistry tentatively assigned as Z.) Substantially identical results were obtained through the use of Schrock's molybdenum alkylidene metathesis catalyst.

As described above, olefin metathesis is therefore amenable to the challenge of constructing the sixteen membered ring containing both the required epoxy and thiazolyl functions of the target system. It is pointed out that no successful olefin metathesis reaction has yet been realized from seco-systems bearing a full compliment of functionality required to reach epothilone. These negative outcomes may merely reflect a failure to identify a

suitable functional group constraint pattern appropriate for macrocyclization.

The Total Synthesis of Epothilone B: Extension of the Suzuki Coupling Method

The present invention provides the first total synthesis of epothilone A (1). D. Meng, et al., *J. Org. Chem.*, **1996**, 61, 7998 P. Bertinato, et al., *J. Org. Chem.*, **1996**, 61, 8000. A. Balog, et al., *Angew. Chem. Int. Ed. Engl.*, **1996**, 35, 2801. D. Meng, et al., *J. Amer. Chem. Soc.*, **1997**, 119, 10073. (For a subsequent total synthesis of epothilone A, see: Z. Yang, et al., *Angew. Chem. Int. Ed. Engl.*, **1997**, 36, 166.) This synthesis proceeds through the Z-desoxy compound (23) which underwent highly stereoselective epoxidation with 2,2-dimethyldioxirane under carefully defined conditions to yield the desired β -epoxide. The same myxobacterium of the genus *Sorangium* which produces 23 also produces epothilone B (2). The latter is a more potent agent than 23, both in antifungal screens and in cytotoxicity/cell nucleus disintegration assays. G. Höfle, et al., *Angew. Chem. Int. Ed. Engl.*, **1996**, 35, 1567; D.M. Bollag, et al., *Cancer Res.* **1995**, 55, 2325.

An initial goal structure was desoxyepothilone B (2C) or a suitable derivative thereof. Access to such a compound would enable the study of the regio- and stereoselectivity issues associated with epoxidation of the C12 - C13 double bond. A key issue was the matter of synthesizing Z-tri-substituted olefinic precursors of 2C with high margins of stereoselection. A synthetic route to the disubstituted system (A. Balog, et al., *Angew. Chem. Int. Ed. Engl.*, **1996**, 35, 2801) employed a palladium-mediated B-alkyl Suzuki coupling (N. Miyaura, et al., *J. Am. Chem. Soc.* **1989**, 111, 314. (For a review, see: N. Miyaura, A. Suzuki, *Chem. Rev.* **1995**, 95, 2457) of the Z-vinyl iodide 19 (Fig. 4(A)) with borane 7C derived from hydroboration of compound 11 (Fig. 1(A)) with 9-BBN (Figure 4(B)).

A preliminary approach was to apply the same line of thinking to reach a Z-tri-substituted olefin (Fig. 17) en route to 2C. Two issues had to be addressed. First, it would be necessary to devise a method to prepare vinyl iodide 8C, the tri-substituted analog of 19. If this goal could be accomplished, a question remained as to the feasibility of conducting the required B-alkyl Suzuki coupling reaction to reach a Z-tri-substituted olefin. The realization of such a transformation with a "B-alkyl" (as opposed to a "B-alkenyl" system) at the inter-molecular level, and where the vinyl iodide is not of the β -iodoenolate (or β -iodoenone) genre, was notprecedented. (For some close analogies which differ in important details from the work shown here, see: N. Miyaura, et al., *Bull. Chem. Soc. Jpn.* **1982**, 55, 2221; M. Ohba, et al., *Tetrahedron Lett.*, **1995**, 36, 6101; C.R. Johnson, M.P. Braun, *J. Am. Chem. Soc.* **1993**, 115, 11014.)

The synthesis of compound 8C is presented in Figure 16. The route started with olefin 10C which was prepared by catalytic asymmetric allylation of 9C (G.E. Keck, et al., *J. Am. Chem. Soc.*, **1993**, 115, 8467) followed by acetylation. Site-selective dihydroxylation

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of **10C** followed by cleavage of the glycol generated the unstable aldehyde **11C**. Surprisingly, the latter reacted with phosphorane **12C** (J. Chen, et al., *Tetrahedron Lett.*, **1994**, 35, 2827) to afford the Z-iodide **8C** albeit in modest overall yield. Borane **7C** was generated from **11** as described herein. The coupling of compound **7C** and iodide **8C** (Fig. 16) could be
5 conducted to produce the pure Z-olefin **13C**.

With compound **13C** in hand, protocols similar to those employed in connection with the synthesis of **23** could be used. (A. Balog, et al., *Angew. Chem. Int. Ed. Engl.*, **1996**, 35, 2801). Thus, cleavage of the acetal linkage led to aldehyde **14C** which was now subjected to macroaldolization (Figure 17). The highest yields were obtained by carrying out the
10 reaction under conditions which apparently equilibrate the C3 hydroxyl group. The 3*R* isomer was converted to the required 3*S* epimer via reduction of its derived C3-ketone (see compound **15C**). The kinetically controlled aldol condensation leading to the natural 3*S* configuration as described in the epothilone A series was accomplished. However, the overall yield for reaching the 3*S* epimer is better using this protocol. Cleavage of the C-5
15 triphenylsilyl ether was followed sequentially by monoprotection (t-butyldimethylsilyl) of the C3 hydroxyl, oxidation at C5 (see compound **16C**), and, finally, cleavage of the silyl protecting groups to expose the C3 and C7 alcohols (see compound **2C**).

It was found that Z-desoxyepothilone B (**2C**) undergoes very rapid and substantially regio- and stereoselective epoxidation under the conditions indicated (although precise
20 comparisons are not available, the epoxidation of **2C** appears to be more rapid and regioselective than is the case with **23**) (A. Balog, et al., *Angew. Chem. Int. Ed. Engl.*, **1996**, 35, 2801), to afford epothilone B (**2**) identical with an authentic sample (¹H NMR, mass spec, IR, [α]_D). Accordingly, the present invention discloses the first total synthesis of epothilone B. Important preparative features of the present method include the enantioselective
25 synthesis of the trisubstituted vinyl iodide **8C**, the palladium-mediated stereospecific coupling of compounds **7C** and **8C** to produce compound **13C** (a virtually unprecedented reaction in this form), and the amenability of Z-desoxyepothilone B (**2C**) to undergo regio- and stereoselective epoxidation under appropriate conditions.

30 Desmethylepothilone A

Total syntheses of epothilones A and B have not been previously disclosed. Balog, A., et al., *Angew. Chem., Int. Ed. Engl.* **1996**, 35, 2801; Nicolaou, K.C., et al., *Angew. Chem., Int. Ed. Engl.* **1997**, 36, 166. Nicolaou, K.C., et al., *Angew. Chem., Int. Ed. Engl.* **1997**, 36, 525; Schinzer, D., et al., *Angew. Chem., Int. Ed. Engl.* **1997**, 36, 523. Su, D.-S.,
35 et al., *Angew. Chem. Int. Ed. Engl.* **1997**, 36, 757. The mode of antitumor action of the epothilones closely mimics that of Taxol® (paclitaxel). Höfle, G., et al., *H. Angew. Chem., Int. Ed. Engl.* **1996**, 35, 1567. Although Taxol® is a clinically proven drug, its formulation

continues to be difficult. In addition, Taxol® induces the multidrug resistance (MDR) phenotype. Hence, any novel agent that has the same mechanism of action as Taxol® and has the prospect of having superior therapeutic activity warrants serious study. Bollag, D. M., et al., *Cancer Res.* **1995**, *55*, 2325.

5 The present invention provides epothilone analogs that are more effective and more readily synthesized than epothilone A or B. The syntheses of the natural products provide ample material for preliminary biological evaluation, but not for producing adequate amounts for full development. One particular area where a structural change could bring significant relief from the complexities of the synthesis would be in the deletion of the C8 methyl group
10 from the polypropionate domain (see target system **3D**). The need to deal with this C8 chiral center complicates all of the syntheses of epothilone disclosed thus far. Deletion of the C8 methyl group prompts a major change in synthetic strategy related to an earlier diene-aldehyde cyclocondensation route. Danishefsky, S. J. *Chemtracts* **1989**, *2*, 273; Meng, D., et al., *J. Org. Chem.* **1996**, *61*, 7998; Bertinato, P., et al., *J. Org. Chem.* **1996**, *61*, 8000.

15 As shown in Fig. 20, asymmetric crotylation (87% ee) of **4D** (Brown, H. C.; Bhat, K. S. *J. Am. Chem. Soc.* **1986**, *108*, 5919), followed by protection led to TBS ether **5D**. The double bond was readily cleaved to give aldehyde **6D**. The aldehyde was coupled to the dianion derived from *t*-butyl isobutyrylacetate to provide **7D**. The ratio of the C_{5S} (**7D**): C_{5R} compound (not shown) is ca 10:1. That the Weiler-type β -ketoester dianion chemistry
20 (Weiler, L. *J. Am. Chem. Soc.* **1970**, *92*, 6702.; Weiler, L.; Huckin, S. N. *J. Am. Chem. Soc.* **1974**, *96*, 1082) can be conducted in the context of the isobutyryl group suggested several alternate approaches for still more concise syntheses. Directed reduction of the C₃ ketone of **7D** following literature precedents (Evans, D. A., et al., *J. Org. Chem.* **1991**, *56*, 741), followed by selective silylation of the C₃ hydroxyl gave a 50% yield of a 10:1 ratio of the
25 required C_{3S} (see compound **8D**) to C_{3R} isomer (not shown). Reduction with sodium borohydride afforded a ca. 1:1 mixture of C₃ epimers. The carbinol, produced upon debenzylolation, was oxidized to an aldehyde which, following methylenation through a simple Wittig reaction, afforded olefin **9D**. Treatment of this compound with TBSOTf provided ester
30 **10D** which was used directly in the Suzuki coupling with the vinyl iodide **12D**.

30 The hydroboration of **10D** with 9-BBN produced intermediate **11D** which, on coupling with the vinyl iodide **12D** and *in situ* cleavage of the TBS ester led to **13D** (Fig. 21). After deacetylation, the hydroxy acid **14D** was in hand. Macrolactonization of this compound (Boden, E. P.; Keck, G. E. *J. Org. Chem.* **1985**, *50*, 2394) produced **15D** which, after desilylation, afforded C₈-desmethyldesoxyepothilone (**16D**). Finally, epoxidation of this compound with
35 dimethyldioxirane produced the goal structure **3D**. The stereoselectivity of epoxidation was surprisingly poor (1.5:1) given that epoxidation of desoxyepothilone A occurred with > 20:1 stereoselectivity. Deletion of the C₈ methyl group appears to shift the conformational

distribution of **16D** to forms in which the epoxidation by dimethyl dioxirane is less β -selective. It is undetermined whether the effect of the C₈ methyl on the stereoselectivity of epoxidation by dimethyldioxirane and the dramatic reduction of biological activity are related.

Compounds **3D** and **16D** were tested for cytotoxicity in cell cultures and assembly of tubulin in the absence of GTP. Microtubule protein (MTP) was purified from calf brains by two cycles of temperature dependent assembly and disassembly. Weisenberg, R.C. *Science* **1972**, 177, 1104. In control assembly experiments, MTP (1 mg/mL) was diluted in assembly buffer containing 0.1 M MES (2-(N-morpholino) ethanesulfonic acid), 1 mM EGTA, 0.5 mM MgCl₂, 1mM GTP and 3M glycerol, pH 6.6. The concentration of tubulin in MTP was estimated to be about 85%. Assembly was monitored spectrophotometrically at 350 nm, 35°C for 40 min by following changes in turbidity as a measure of polymer mass. Gaskin, F.; Cantor, C.R.; Shelanski, M.L.J. *Mol. Biol.* **1974**, 89, 737. Drugs were tested at a concentration of 10 μ M, in the absence of GTP. Microtubule formation was verified by electron microscopy. To determine the stability of microtubules assembled in the presence of GTP or drug, turbidity was followed for 40 min after the reaction temperature was shifted to 4°C.

Cytotoxicity studies showed drastically reduced activity in the 8-desmethyl series. Compounds **3D** and **16D** were approximately 200 times less active than their corresponding epothilone A counterparts (see Table 1). Recalling earlier SAR findings at both C₃ and C₅, in conjunction with the findings disclosed herein, the polypropionate sector of the epothilones emerges as a particularly sensitive locus of biological function. Su, D.-S., et al., *Angew. Chem. Int. Ed. Engl.* **1997**, 36, 757; Meng, D., et al., *J. Am. Chem. Soc.* **1997**, 119.

Table 1. Relative efficacy of epothilone compounds against drug-sensitive and resistant human leukemic CCRF-CEM cell lines.^a

Compound	CCRF-CEM IC ₅₀ (μ M) ^b	CCRF-CEM/VBL IC ₅₀ (μ M) ^b	CCRF-CEM/VM ₁ IC ₅₀ (μ M) ^b
16D	5.00	5.75	6.29
3D	0.439	2.47	0.764
epothilone A	0.003	0.020	0.003
desoxyepothilone A	0.022	0.012	0.013
epothilone B	0.0004	0.003	0.002
desoxyepothilone B	0.009	0.017	0.014
paclitaxel	0.002	3.390	0.002

^aThe cytotoxicities of test compounds were determined by the growth of human lymphoblastic leukemic cells CCRF-CEM, or their sublines resistant to vinblastine and Taxol® (CCRF-CEM/VBL) or resistant to etoposide (CCRF-CEM/VM-1). XTT-microculture tetrazolium/formazan assays were used.

^bThe IC₅₀ values were calculated from 5-6 concentrations based on the median-effect plot using computer software.

Desoxyepothilone B: an Effective Microtubule-targeted Antitumor Agent with a Promising *in Vivo* Profile Relative to Epothilone b

The epothilones have been synthesized as herein disclosed and evaluated for antitumor potential *in vitro* and *in vivo*. Epothilones and paclitaxel are thought to share similar mechanisms of action in stabilizing microtubule arrays as indicated by binding displacement studies, substitution for Taxol® in Taxol®-dependent cell growth, and electron microscopic examinations. Cell growth inhibitory effects have been determined in two rodent and three human tumor cell lines and their drug resistant sublines. While Taxol® showed as much as 1970-fold cross-resistance to the sublines resistant to Taxol®, adriamycin, vinblastine or actinomycin D, most epothilones exhibit little or no cross-resistance. In multidrug resistant CCRF-CEM/VBL₁₀₀ cells, the 50% cell growth inhibitory concentrations (IC₅₀ values) for epothilone A, epothilone B, desoxyepothilone A, desoxy epothilone B and Taxol® were 0.02, 0.002, 0.012, 0.017 and 4.14 μ M, respectively. *In vivo* studies, using i.p. administration, indicate that the parent, epothilone B, is highly toxic to mice with little therapeutic effect when compared with lead compound desoxyepothilone B (25-40 mg/kg, Q2Dx5, i.p.), which showed far superior therapeutic effect and lower toxicity than paclitaxel, doxorubicin, camptothecin or vinblastine (at maximal tolerated doses) in parallel experiments. In nude mice bearing a human mammary carcinoma xenograft (MX-1), marked tumor regression and cures have been obtained with desoxyepothilone B.

The isolation of the naturally occurring macrolides epothilone A and epothilone B from the myxobacteria *Sorangium cellulosum* (Hoefle, G., et al., *Angew.Chem.Int.Ed.Engl.* 1996, 35, 567-1569; Gerth, K., et al. *J. Antibiot.* 1996, 49, 560-563) and the subsequent demonstration of their ability to stabilize microtubule arrays *in vitro* elicited considerable interest in this class of compounds (Bollag, D.M., et al., *Cancer Res.* 1995, 55, 2325-2333; Su, D.-S., et al., *Angew. Chem. Int. Ed. Engl.* 1997, 36, 2093-2096; Meng, D., et al., *J. Am. Chem. Soc.* 1997, 119, 2733-2734; Muhlradt, P.F. & Sasse, F. *Cancer Res.* 1997, 57, 3344-3346; Service, R.E. *Science* 1996, 274, 2009). We have recently conducted the total synthesis of these natural products as well as over 45 related analogs (Meng, D., et al., *J. Am. Chem. Soc.* 1997, 119, 10073-10092; Su, D.-S., et al., *Angew. Chem. Int. Ed. Engl.* 1997, 36, 757-759; Chou, T.-C., Zhang, X.-G., & Danishefsky, S.J. *Proc. Am. Assoc. Cancer Res.* 1998, 39, 163-164) in order to investigate their chemical structure-biological activity relationships (Su, D.-S., et al., *Angew. Chem. Int. Ed. Engl.* 1997, 36, 2093-2096). The studies disclosed herein allowed the characterization of the epothilone structure in three zones. Thus, in the C-1~8 acyl sector, the present inventors have determined that structural changes are not tolerated in terms of *in vitro* cytotoxicity and microtubule stabilizing ability. This stands in contrast to the C-9~15 O-alkyl sector and the C-15 pendant aryl sectors wherein considerable modification of structures is tolerated (Su, D.-S., et al., *Angew. Chem. Int. Ed. Engl.* 1997, 36, 2093-2096; Meng, D., et al., 1997, *J. Am. Chem. Soc.* 119, 10073-10092). Described herein are

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the results of *in vitro* and *in vivo* experiments on the Z-12,13 desoxy version of epothilone B (desoxyepothilone B).

It has been shown that the natural epothilones A and B have a similar mechanism of action to paclitaxel (Taxol®) although structurally diverse (Su, D.-S., *et al.*, *Angew. Chem. Int. Ed. Engl.* 1997, 36, 2093-2096; Meng, D., *et al.*, *J. Am. Chem. Soc.* 1997, 119, 2733-2734; Schiff, P.B., Fant, J. & Horwitz, S.B. *Nature* 1979, 277, 665-667; Landino, L.M. & MacDonald, T.L., in: *The Chemistry and Pharmacology of Taxol and Its Derivatives*, Favin, V., ed., Elsevier, New York 1995,, Chapter 7, p. 301). Paclitaxel, isolated from the Pacific yew tree (*Taxus brevifolia*), has been widely used clinically to treat a variety of solid cancers including neoplasms of ovary, breast, colon and lung (Landino, L.M. & MacDonald, T.L. *id.*; Rose, W.C. *Anti-Cancer Drugs*, 1992, 3, 311-321; Rowinsky, E.K., *et al.*, *Seminars Oncol.* 1993, 20, 1-15). Epothilones A and B as well as Taxol® stabilize microtubule assemblies as demonstrated by binding displacement, substitution for paclitaxel in paclitaxel-dependent cell growth, and electron microscopic examinations (Bollag, D.M., *et al.*, *Cancer Res.* 1995, 55, 2325-2333). Despite these similarities, the epothilones are more water soluble than paclitaxel, thereby offering potentially distinct advantages for formulation. Epothilones are more potent than paclitaxel in inhibiting cell growth, especially against cells expressing P-glycoprotein (Pgp) that are multidrug resistant (MDR), including cross-resistance to paclitaxel (Bollag, D.M., *id.*; Su, D.-S., *et al.*, *Angew. Chem. Int. Ed. Engl.* 1997, 36, 2093-2096).

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Materials and Methods

All stock solutions of the above (except VBL in saline) were prepared using dimethylsulfoxide (DMSO) as a solvent and were further diluted to desired concentrations for experimental use. The final concentration of DMSO in tissue culture was 0.25% (v/v) or less to avoid solvent cytotoxicity. For *in vivo* studies, paclitaxel in Cremophor-EtOH was further diluted with DMSO as needed. Vinblastine sulfate (Velban) (Eli Lilly & Co. Indianapolis, IN), and doxorubicin or adriamycin HCl (DX or Adr) (Pharmacia, Columbus, OH) in saline were diluted with DMSO as needed. DMSO was used as a vehicle for epothilones. Each mouse received $\leq 40\mu\text{L}$ DMSO in all experiments.

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Cell Lines

The CCRF-CEM human T-cell acute lymphoblastic leukemia cell line and its vinblastine-resistant (CCRF-CEM/VBL₁₀₀) and teniposide-resistant (CCRF-CEM/VM₁) sublines (Cass, C.E., *et al.*, 1989, *Cancer Res.* 49, 5798-5804; Danks, M.K., Yalowich, J.C., & Beck, W.T. 1987, *Cancer Res.* 47, 1297-1301) were used. CCRF-CEM/Taxol® was developed by the present inventors following continuous exposure of CCRF-CEM cells with increasing concentrations of paclitaxel (at IC₅₀ - IC₉₀) for ten months. The fresh medium with paclitaxel

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was replenished every week. The CCRF-CEM/Taxol[®] exhibited 57-fold resistance to paclitaxel ($IC_{50} = 0.0021 \mu M$, see Table 1A). The DC-3F hamster lung fibroblast cell line and its actinomycin D-selected sublines (DC-3F/ADII and DC-3F/ADX) were obtained from the Memorial Sloan-Kettering Cancer Center (MSKCC). The murine leukemic P388/0 and its
5 doxorubicin-selected subline (P388/DX) as well as human neuroblastoma SK-N-As and its doxorubicin-selected subline (SK-N-FI/Adr) were obtained from MSKCC.

The drug-resistant cell lines were continuously cultured in the presence of the selecting agent, AD, DX, VBL or VM to maintain the drug resistant phenotypes. Each sub-cell line was cultured for one to two passages in an appropriate concentration (e.g. IC_{50}) of the
10 drug, which was then removed from the media and the cells were rested in fresh media for a minimum of 4 days before each assay. All cells were cultured in RPMI 1640-10% FBS at 37°C, 5% CO₂ (see below).

Cytotoxicity Assays

15 The cells were cultured at an initial density of 5×10^4 cells/mL. They were maintained in a 5% CO₂-humidified atmosphere at 37°C in RPMI-1640 medium (GIBCO-BRL, Gaithersburg, MD) containing penicillin (100U/mL), streptomycin (100 mg/mL) (GIBCO-BRL) and 10% heat inactivate fetal bovine serum. Culture for cell suspension (such as for CCRF-CEM, P388 and sublines), were performed by the XTT-microculture tetrazolium method
20 (Scudiero, D.A. *et al.*, *Cancer Res.* 1988, 48, 4827-4833) in duplicate in 96-well microtiter plates.

2',3'-Bis(methoxy-4-nitro-5-sufophenyl)-5-[(phenylamino)carbonyl]-2H-tetrazolium hydruoxide (XTT) was prepared at 1 mg/mL in prewarmed (37°C) medium without serum. Phenazine methosulfate (PMS) and fresh XTT were mixed together to obtain 0.025 mM PMS-
25 XTT solution (25 μL of the stock 5 mM PMS was added per 5 mL of 1 mg/mL XTT). Following a 72 h incubation, 50 μL of the assay aliquots were added to each well of the cell culture. After incubation at 37°C for 4h, absorbance at 450 nm and 630 nm was measured with a microplate reader (EL340, Bio-Tek Instruments, Inc., Winooski, VT).

The cytotoxicity of the drug toward the monolayer cell cultures (such as DC-3F, MCF-
30 7, SK-N-As and sublines) was determined in 96-well microtiter plates by the SRB method as described by Skehan and co-workers (Skehan, P., *et al.*, *J. Natl. Cancer Inst.* 1990, 82, 1107-1112) for measuring the cellular protein content. Cultures were fixed with trichloroacetic acid and then stained for 30 min with 0.4% sufurhodamine B dissolved in 1% acetic acid. Unbound dye was removed by acetic acid washes, and the protein-bound dye was extracted
35 with an unbuffered Tris base (tris(hydroxy-methyl)aminomethane) for determination of absorbance at 570 nm in a 96-well microtiter plate reader. The experiments were carried out in duplicate. Each run entailed six to seven concentrations of the tested drugs. Data were

analyzed with the median-effect plot (Chou, T.-C. & Talalay, P.T. (1984) *Adv. Enzyme Regul.* 22, 27-55) using a previously described computer program (Chou, J., & Chou T.-C. 1987, *Dose-effect analysis with microcomputers: Quantitation of ED₅₀, synergism, antagonism, low-dose risk, reception-ligand binding and enzyme kinetics*, IBM-PC software and manual, Biosoft, Cambridge, U.K.).

Stability of Desoxyepothilone B in Plasma

HPLC Method.

Sample Preparation. To 300 microliters of spiked plasma are added 30 microliters of methanol. The mixture is agitated and allowed to stand for 2 minutes. Then 600 microliters of methanol are added. The mixture is centrifuged. The supernatant is removed for analysis by HPLC. Analyses were performed under the following chromatographic conditions: Column: Nova-Pak C18, 15 cm. Eluant: 50% acetonitrile/water with 0.8% triethylamine, 0.2% phosphoric acid. Detection: UV (250 nm).

Animals

Athymic nude mice (nu/nu) were used for MX-1 and MCF-7/Adr human mammary carcinoma xenografts. Mice were obtained from Taconic Laboratory Animals and Service (Germantown, NY: outbred, Swiss background). Male mice 6-8 weeks old, weighing 20 -25g were used.

RESULTS

Structure-activity Relationships

To determine structure-activity relationships of epothilones (Su, D.-S., et al., *Angew. Chem. Int. Ed. Engl.* 1997, 36, 2093-2096), the susceptibility of CCRF-CEM leukemic cells and the respective drug-resistant sublines CCRF-CEM/VBL₁₀₀ (Pgp-MDR cells) (Cass, C.E., et al., *Cancer Res.* 1989, 49, 5798-5804) and CCRF/CEM/VM₁ (cells with a mutated topo II gene) (Danks, M.K., Yalowich, J.C., & Beck, W.T. *Cancer Res.* 1987, 47, 1297-1301) to epothilones A and B and desoxyepothilone B (Table 1A) were determined. Although/VBL₁₀₀ is 527-fold resistant to VBL and 1970-fold resistance to paclitaxel, the epothilones A and B exhibited only 6.1-7.4-fold resistance, while desoxyepothilones A and B evidenced only 0.6-1.8-fold resistance. Using paclitaxel as the selecting agent, CCRF-CEM/Taxol® was grown 57-fold resistant and found to be 10.9-fold resistance to VBL. By contrast, DX, AD and VP-16 showed only 2.3-4.5 fold resistance, and epothilones A and B showed very little resistance (i.e., 1.4-3.1-fold) and desoxyepothilones A and B displayed almost no resistance (i.e., 0.7-1.7 fold) (Table 1A). CCRF-CEM/VM₁ cells that were 117-fold resistant to etoposide were

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sensitive to all epothilones or desoxyepothilones listed in Table 1A with only 0.6-3.6 fold resistance.

Table 1A. Susceptibility of CCRF-CEM and its drug resistant sublines to epothilone derivatives.

Compound	(A) CCRF- CEM	(B) CCRF- CEM/VBL ₁₀₀	(C) CCRF- CEM/ Taxol®	(D) CCRF- CEM/VM ₁	(B)(A)	(C)(A)	(D)(A)
IC ₅₀ (μM)*							
Epo A	0.0027	0.020	0.0037	0.0061	7.4	1.4	2.3
Epo B	0.00035	0.0021	0.0011	0.0013	6.1	3.1	3.6
dEpo A	0.0220	0.012	0.0150	0.013	0.55	0.7	0.59
dEpo B	0.0095	0.017	0.0162	0.014	1.8	1.7	1.5
Taxol®	0.0021	4.140	0.120	0.0066	1971	57	3.1
Vinblastine	0.0063	0.332	0.0069	0.00041	527	10.9	0.7
Etoposide	0.290	10.30	1.32	34.4	35	4.5	117
Adriamycin	0.036	1.74	0.082	0.128	48	2.3	3.6
Actinomycin	0.00035	0.038	0.0013	0.00027	109	3.7	0.8
D							

*Cell growth inhibition was measured by XTT tetrazonium assay (Scudiero, D.A. et al., *Cancer Res.* 1988, 48, 4827-4833) following 72 h incubation for cell growth as described previously. The IC₅₀ values were determined with 6-7 concentrations of each drug using a computer program (Chou, T.-C. & Talalay, P.T. (1984) *Adv. Enzyme Regul.* 22, 27-55); Chou, J., & Chou T.-C., *Dose-effect analysis with microcomputers: Quantitation of ED₅₀, synergism, antagonism, low-dose risk, reception-ligand binding and enzyme kinetics*, 1987, IBM-PC software and manual, Biosoft, Cambridge, U.K.)

Toxicity of dEpoB vs. EpoB

The toxicity of EpoB and dEpoB was compared in normal athymic nude mice on the daily i.p. schedule. EpoB at 0.6 mg/kg, QDX4, i.p. led to lethality in all eight mice. In contrast, in the group treated with dEpoB 25 mg/kg, QDX5, i.p., zero of six mice died. It was also observed that the vehicle treated control group showed a steady increase in body weight and the dEpoB treated mice maintained approximately the same average body weight, whereas the EpoB treated group showed steady decreases in body weight until death. These results indicated a higher toxicity for both EpoB and dEpoB than in tumor bearing nude mice

when the treatment schedule was Q2Dx5, i.p. (see Tables 1C and 1D). In the preliminary studies, for the non-tumor bearing nude mice receiving EpoB 0.6 mg/kg or dEpoB 25 mg/kg, QDx4, i.p., there were no apparent changes in hematological cell counts or blood chemistry parameters except for a 43% decrease in lymphocytes. Similar leukopenia was found with 5 paclitaxel. Some obstructive fecal mass in the large intestine was noted following Epo treatments in the preliminary study. No gross pathological abnormalities were observed in other organs.

10 **Table 1B.** Toxicity of Epothilone B, and Desoxyepothilone B in normal nude mice.

Group	Dose schedule and route of administration	Number of mice	Number of mice died
Control		4	0
Epothilone B	0.6 mg/kg, QD x 4, i.p.	8	8*
Desoxyepothilone B	25 mg/kg, QD x 4, i.p.	6	0

* Mice died of toxicity on day 5,6,6,7,7,7,7,7

Comparison of Different Routes of Administration

Nude mice bearing human ovarian adenocarcinoma, SK-OV3, and 20 human mammary adenocarcinoma, MX-1, were treated with dEpoB, both i.p. (DMSO as solvent) and i.v. (cremophor and EtOH, 1:1), with Taxol®, i.p. and i.v. (both with clinical samples in cremophor and EtOH as specified by the manufacturer), and with EpoB, i.v. (used cremophor and EtOH, 1:1). As shown in Table 6, for Q2Dx5 schedule, dEpoB, i.p. (35mg/kg) and Taxol® i.v. 25 (15 mg/kg) both yield potent therapeutic effects against MX-1 with tumor-size on day 19, treated/control = 0.02 and 0.01, respectively (see Table 1F). For the ovarian tumor a lesser therapeutic effect was seen, tumor size on day 21, treated/control = 0.28 for both drugs (see Table 1G). For EpoB i.v., at 0.6 mg/kg there was less therapeutic effect and more toxicity than for dEpoB and 30 Taxol®. In contrast, dEpoB, i.v. (15mg/kg) and Taxol®, i.p. (5mg/kg) showed more toxicity and less therapeutic effect against both tumors. Thus, dEpoB

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showed the best results when given i.p. and Taxol® gave better results when given i.v. in cremophor and EtOH.

5 In Vitro Effect against Various Tumor Sublines

Further susceptibility evaluations were conducted for epothilones A and B and desoxyepothilones A and B in four additional tumor cell lines and four of their drug resistant sublines (Table 1C). Hamster lung tumor cells DC-3F/ADX, that were selected 13,000-fold resistant to AD, were found to be 328-fold resistant to paclitaxel and 124-fold resistant to DX when compared with the parent cell line (DC-3F). In contrast, epothilones A and B and desoxyepothilone A showed only 3.9~28-fold resistance, and epothilones A and B and desoxyepothilone B showed no cross-resistance (0.9-fold resistance).

Murine leukemic P388/Adr cells that were selected 482 -fold resistant to DX, were found to be 111-fold resistant to paclitaxel. However, epothilones A and B showed less than 6-fold resistance, and for desoxyepothilone A and B there was no cross-resistance (<0.6-fold resistance).

Human neuroblastoma cells, SK-N-F1, that were selected as 18-fold resistant to DX, were found to be 80-fold resistant to paclitaxel. By contrast, epothilone B was 25-fold resistant, while the resistance of epothilone A and desoxyepothilones A and B was only between 1.9 and 3.1.

Human mammary carcinoma cells, MCF-7/Adr, that were selected 3.8-fold resistant to DX, were found to be 46-fold resistant to paclitaxel. In contrast, compounds epothilones A and B and desoxyepothilone B was 3.1~5.4-fold resistant, and dEpoB showed only 2.4-fold resistant. Overall, dEpoB was the least cross-resistant among epothilones and desoxyepothilones in various drug-resistant tumor sublines. By contrast, paclitaxel suffers from marked cross-resistance in tumor cells that were selected to be resistant to VBL, DX or AD. In three out of five cell lines studied, cross-resistance to paclitaxel was even greater than that of the selecting agents.

30 Therapeutic Effects against MX-1 Xenografts

Therapeutic effects of compounds epothilone A and desoxyepothilone B, paclitaxel, VBL and CPT were evaluated in athymic nude mice bearing human mammary adenocarcinoma MX-1 xenografts (Table 1D). Desoxyepothilone B at a 15 mg/kg dose i.p. on days 7, 9, 11, 13 and 15 produced a 50~60% tumor volume reduction when compared to the control group. A higher dose of drug, 25 mg/kg, produced as much as 96% average tumor volume reduction measured two days after the last treatment (i.e., on day 17). These effects were achieved with no lethality nor body weight reduction. Furthermore, with a 25 mg/kg dose, one out of six

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mice was tumor-free on day 35 after tumor implantation (i.e. on day 35). In contrast, after treatment with EpoB (0.3 mg/kg and 0.6 mg/kg, i.p., on days 7, 9, 11, 13 and 15), the average body weight decreased over 1 g and 2 g, respectively. In the case of 0.6 mg/kg treatment, three out of seven mice died of toxicity. Despite the apparent toxicity at these doses, EpoB appeared to have only marginal therapeutic effect, as only 16% to 26% tumor volume reduction was observed (Table 1D). The parallel experiments for paclitaxel led to a lower therapeutic effect. In animals treated with paclitaxel, 5 mg/kg, there was 55% reduction in tumor volume and no decrease in average body weight. At a dose of 10 mg/kg, paclitaxel showed a 89% tumor reduction, however, four out of seven mice died of toxicity. For DX (2-3 mg/kg) and CPT (1.5-3 mg/kg) i.e., near the maximal tolerated doses, inferior results were obtained when compared with dEpoB. Thus, dEpoB even at non-toxic dose had the best therapeutic effect among the five compounds studied under the same experimental conditions.

In a separate experiment, MX-1 xenograft-bearing mice were treated with dEpoB, 35 mg/kg, Q2Dx5, i.p. beginning on day 8 after tumor implantation (Fig. 60). On day 16, two out of ten mice had no detectable tumor. These ten mice were further treated with dEpo B, 40 mg/kg, Q2Dx5 beginning on day 18. At the end of treatment on day 26, five out of ten mice had no detectable tumor, and three remained tumor-free on day 60. There was body weight reduction during treatments but no lethality occurred. In a parallel experiment, ten mice were treated with paclitaxel, 5 mg/kg, Q2Dx5, i.p. from day 8 to day 16, followed by a second cycle of treatment in the same manner from day 18 to day 26. The tumor sizes were reduced but continued to grow during treatment and by day 24, the average tumor size was $2285 \pm 597 \text{ mm}^3$ (n = 10). In a parallel experiment, DX was given 2 mg/kg, Q2Dx5, i.p. (Fig. 60), and reduced therapeutic effect was seen compared to dEpoB or paclitaxel. No data after day 18 is shown because the tumor burden in the control group was excessive and the mice in this group were sacrificed.

Therapeutic Effects against MCF-7/Adr Xenografts

The therapeutic effects of dEpoB, Taxol®, DX and CPT were also evaluated in nude mice bearing xenografts of human mammary adenocarcinoma resistant to DX (MCF-7/Adr) (Table 1E). As indicated earlier in Table 1B for the cytotoxicity results *in vitro*, MCF-7/Adr cells selected to be 3.8-fold resistant to DX were found to be 46-fold resistant to paclitaxel, and only 2.4-fold resistant to dEpoB. For *in vivo* studies, each drug was given Q2Dx5, i.p. beginning on day 8 after tumor implantation. Paclitaxel 12 mg/kg and DX 3 mg/kg were highly toxic to the nude mice with 3/7 and 3/6 lethality, respectively. CPT 3 mg/kg led to moderate toxicity without lethality, and dEpoB 35 mg/kg showed negligible toxicity as shown by minimal body weight changes (Table 1E). CPT at 3 mg/kg reduced 57% of tumor size on day 17 (p < 0.05 when compared with control group). Desoxyepothilone B at 35 mg/kg

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significantly suppressed tumor size by 66~73% when compared with the control group ($p < 0.005-0.05$), without complete tumor regression. In contrast, paclitaxel 5 mg/kg, and DX 2 mg/kg, produced slight growth suppression of this drug-resistant tumor which was not significantly different from the control group (see Table 1D). Thus, dEpoB stands out as the superior drug among the four tested against this drug-resistant tumor.

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Table 1C. Comparison of in vitro growth inhibition potency of epothilone derivatives against various parent and drug resistant tumor cell lines.

Compound	DC-3F	DC-3F/ADX	P388/0	P388/Adr	SK-N-As	SK-N-FI	MCF-7	MCF-7/Adr
IC ₅₀ (μM)*								
Epo A	0.0037	0.053 (14.5x)*	0.0018	0.0010 (5.3x)*	0.012	0.023 (1.9x)*	0.0030	0.0094 (3.1x)*
Epo B	0.0006	0.017 (28x)	0.00029	0.0016 (5.5x)	0.004	0.010 (25x)	0.0005	0.0027 (5.4x)
dEpo A	0.011	0.042 (3.9x)	0.0213	0.0125 (0.59x)	0.073	0.223 (3.1x)	0.032	0.144 (4.5x)
dEpo B	0.00097	0.00091 (0.9x)	0.0068	0.0042 (0.62x)	0.021	0.046 (2.2x)	0.0029	0.0071 (2.4x)
Taxol®	0.095	32.0 (338x)	0.0029	0.326 (111x)	0.0016	0.130 (80x)	0.0033	0.150 (46x)
Actinomycin D	0.00044	0.572 (13000x)	0.00015	0.0012 (8x)	0.00085	0.0119 (14x)	0.00068	0.00167 (2.5x)
Adriamycin	0.018	2.236 (124x)	0.0055	2.65 (482x)	0.077	1.42 (18.4x)	0.057	0.216 (3.8x)

* Cell growth inhibition was measured by protein staining SRB assay (Skehan, P., et al., J. Natl. Cancer Inst. 1990, 82, 1107-1112) following 72 h incubation as described previously. The IC₅₀ values were determined with 6-7 concentrations of each drug using a computer program (Chou, T.-C. & Talalay, P.T., Adv. Enzyme Regul. 1984, 22, 27-55; Chou, J., & Chou T.-C., Dose-effect analysis with microcomputers: Quantitation of ED₅₀ synergism, antagonism, low-dose risk, receptor-ligand binding and enzyme kinetics, 1987, IBM-PC software and manual. Biosoft, Cambridge, U.K.). * Numbers in parentheses are folds of resistance based on the IC₅₀ ratio when compared with the corresponding parent cell lines except for P388/0 and P388/Adr, XTT assay (Scudiero, D.A., et al., Cancer Res. 1988, 48, 4827-4833) was used.

Table 1D. Therapeutic effect of desoxyepothilone B, epothilone B, Taxol®, vinblastine and camptothecin in nude mice bearing human MX-1 xenograft.

Drug	Dose (mg/kg)	Average Body Weight Change (g)						Average Tumor Size (T/C)					Toxicity Death	N
		Day 7	11	13	15	17	Day 11	13	15	17				
Control		27.2	+0.8	+1.1	+1.9	+0.6	1.00	1.00	1.00	1.00	0/8	8		
	15	27.1	+0.8	+1.1	+1.6	+1.5	0.65	0.46	0.49**	0.41**	0/6	6		
dEpo B	25 [#]	27.0	+0.4	+0.7	+1.0	+0.7	0.38*	0.11**	0.05***	0.04****	0/6	6		
	0.3	26.9	+0.5	+0.4	-0.3	-1.2	1.00	0.71	0.71	0.84	0/7	7		
Epo B	(0.6) [†]	27.4	-0.3	-1.3	-2.1	-2.1	1.08	0.73	0.81	0.74	3/7) [#]	7		
	5	26.9	-0.1	+0.4	+1.1	+1.2	0.54	0.46	0.40*	0.45**	0/7	7		
Taxol®	10 [†]	27.6	-2.7	-1.1	-0.3	+2.2	0.43	0.37	0.12	0.11	4/7) [#]	7		
Vinblastine	0.2	25.7	+0.6	+1.4	+2.3	+2.9	0.65	0.54	0.56	0.88	0/7	7		
	(0.4) [†]	26.4	+0.8	+0.5	+1.9	+2.1	0.80	0.56	0.83	0.88	1/7) [#]	7		
Camptothecin	1.5	27.4	-0.9	-0.7	-0.4	+1.0	0.61	0.45*	0.32*	0.36**	0/7	7		

MX-1 tissue 50 μ l/mouse was implanted s.c. on day 0. Every other day i.p. treatments were given on days 7, 9, 11, 13, 15; The average tumor volumes of the control group on day 11, 13, 15 and 17 were 386 ± 120 , 915 ± 245 , 1390 ± 324 , and 1903 ± 319 mm³ (mean \pm SEM), respectively; * $P < 0.05$, ** $P < 0.01$, *** $P < 0.005$, **** $P < 0.001$; [†]One out of six mice with no detectable tumor on day 35; [†]Three mice died of drug toxicity on day 17; ^{*}Four mice died of drug toxicity on day 13, 13, 13, 15; [†]One mouse died of drug toxicity on day 15; ^{**}P values were not shown due to toxic lethality.

Table 1E. Therapeutic effects of desoxyepothilone B, epothilone B, taxol, adriamycin and camptothecin in nude mice bearing MDR human MCF-7/Adr tumor.

Drug	Dose (mg/kg)	Average Body Weight Change (g)					Average Tumor Size (T/C)					Toxicity Death	N
		Day 8	11	13	15	17	Day 11	13	15	17			
Control	0	25.0	+2.0	+2.6	+3.1	+3.7	1.00	1.00	1.00	1.00	0/8	8	
dEpo B	35	25.0	0.3	+0.7	+0.6	+0.8	0.31**	0.27***	0.30***	0.34*	0/8	8	
Taxol®	6 (12)	25.3 24.5	+1.7 -0.7	+1.8 -1.3	+0.8 -2.4	+0.9 0	0.57 0.50	0.66 0.51	0.85 0.32	0.90 0.40	0/7 3/7	7 7)*	
Adriamycin	2 (3)	25.6 24.6	+0.2 +0.5	-0.4 -1.3	-0.6 -3.2	-0.4 -1.6	0.70 0.66	0.68 0.83	0.84 0.57	0.78 0.53	0/8 3/6	8 6)*	
Camptothecin	1.5 (3)	24.4 24.5	+1.1 -0.6	+0.9 -0.4	+1.7 -0.8	+1.4 -0.9	1.08 0.95	0.72 0.76	0.61 0.61	0.72 0.43*	0/8 0/6	8 6	

MCF-7/Adr cell 3×10^6 /mouse was implanted s.c. on day 0. Every other day ip treatments were given on days 8, 10, 12, 14 and 16. The average tumor size of control group on day 11, 13, 15 and 17 was 392 ± 84 , 916 ± 210 , 1499 ± 346 , and $2373 \pm 537 \text{ mm}^3$ respectively (mean \pm SEM). * $< P0.05$, ** $P < 0.01$, *** $P < 0.005$; * P values were not shown due to lethality.

Table 1F. Therapeutic effects of desoxyopothilone B, Epo B and Taxol® in nude mice bearing MX-1 tumors using different vehicles and different routes of administration.^a

Drug/Route	Dose (mg/kg)	Average Body Weight Change (g)						Average Tumor Size (T/C)				Tumor Disapp.	Toxicity Death
		Day 9	13	15	17	19	Day 13	15	17	19			
Control	0	26.4	-0.2	-0.4	+0.2	+0.8	1.00	1.00	1.00	1.00	0/6	0/6	
dEpo B/i.p.	35	27.8	-1.7	-2.1	-2.1	-2.4	0.35	0.14	0.04	0.02	3/6	0/6	
dEpo B/i.v.	15	27.0	0	-0.6	-1.1	-2.6	0.47	0.30	0.10	0.04	0/6	4/6 ^b	
Epo B/i.p.	0.6	27.0	-0.9	-0.5	-3.3	-3.4	0.67	0.63	0.61	0.51	0/6	0/6	
Taxol®/i.p.	5	27.4	-1.1	-2.0	-1.0	-0.2	0.59	0.72	0.59	0.55	0/6	0/6	
Taxol®/i.v.	15	27.2	-0.6	-0.8	-0.8	-0.9	0.36	0.13	0.04	0.01	2/6	0/6	

a: 50 µg tumor tissue was implanted s.c. on day 0. Every other day i.p. or i.v. treatments were given on days 9, 11, 13, 15 and 17. The average tumor size of control group on day 13, 15, 17 and 19 was 274, 378, 677, 1139mm³ respectively.

b: 4/6 mice died of drug toxicity on day 23, 23, 23, 25.

Table 1G. Therapeutic effects of desoxyopothilone B, Epo B and Taxol® in nude mice bearing SK-OV-3 tumors using different vehicles and different routes of administration.^a

Drug/Route	Dose (mg/kg)	Average Body Weight Change (g)						Average Tumor Size (T/C)					Tumor	Toxicity Death
		Day 9	13	15	17	19	Day 15	17	19	21				
Control	0	26.4	-0.2	-0.4	+0.2	+0.8	1.00	1.00	1.00	1.00	0/6	0/6	0/6	
dEpo B/i.p.	35	27.8	-1.7	-2.1	-2.1	-2.4	0.57	0.33	0.35	0.28	0/6	0/6	0/6	
dEpo B/i.v.	15	27.0	0	-0.6	-1.1	-2.6	0.86	0.56	0.50	0.44	0/6	0/6	4/6 ^b	
Epo B/i.p.	0.6	27.0	-0.9	-0.5	-3.3	-3.4	0.75	0.69	0.88	0.77	0/6	0/6	0/6	
Taxol®/i.p.	5	27.4	-1.1	-2.0	-1.0	-0.2	0.69	0.60	0.49	0.40	0/6	0/6	0/6	
Taxol®/i.v.	15	27.2	-0.6	-0.8	-0.8	-0.9	0.97	0.67	0.42	0.28	0/6	0/6	0/6	

a: 50 µg tumor tissue was implanted s.c. on day 0. Every other day i.p. or i.v. treatments were given on days 9, 11, 13, 15 and 17. The average tumor size of control group on day 13, 15, 17 and 19 was 274, 378, 677, 1139mm³ respectively.

b: 4/6 mice died of drug toxicity on day 23, 23, 23, 25.

DISCUSSION

Two classes of naturally occurring compounds, epothilones and paclitaxel, which are apparently structurally dissimilar, show similar modes of action in stabilizing microtubule assemblies. These similarities include binding tubulin, substitution for paclitaxel in
5 maintaining paclitaxel-dependent cell growth in a resistant cell line, and similar morphologic changes as determined by electron microscopic examination of the drug-microtubule complex. There are differences, however, between the two classes of compounds. These differences are most prominently exhibited by the lack of cross-resistance in cytotoxicity between the epothilones and paclitaxel even in CCRF-CEM/Taxol® cells (Table 1A). Furthermore, in
10 CCRF/CEM/VBL₁₀₀, the cells were 527-fold resistant to vinblastine and 1971-fold resistance to paclitaxel, but were only 6.1-fold resistant to EpoB and 1.8-fold resistant to dEpoB (Table 1A). In DC-3F/ADX cells, there was 13,000-fold resistance to actinomycin D and 338-fold resistance to paclitaxel. However, these cells were only 28-fold resistance to EpoB and had no resistance to dEpoB (i.e., 0.9-fold resistance or collateral sensitivity) (Table 1B). Paclitaxel showed a
15 higher degree of cross-resistance in these cell lines than other MDR-drugs such as doxorubicin, actinomycin D, vinblastine or etoposide. In some cases the degrees of resistance to paclitaxel were even greater than those of the resistance-selecting agent (e.g., CCRF-CEM/VBL₁₀₀ in Table 1A, and SK-N-FI and MCF-7-Adr in Table 1B). In contrast, among all compounds tested, dEpoB showed the least cross-resistance in several drug-resistant cell lines (e.g. DC-3F/Adr) and even
20 showed slight collateral sensitivity (e.g. DC-3F/ADX and P388/Adr in Table 1B). Parallel cancer chemotherapeutic studies for EpoB, dEpoB, Taxol® and other drugs were performed under the same experimental conditions (i.e., treatment schedule, Q2D; solvent vehicle, DMSO; and route of administration, i.p.) in animals.

The i.p. route of other formulations for administration of dEpo B is far better tolerated
25 than the i.v. method. Even though EpoB is the most potent, it is by no means the best candidate for cancer therapy in terms of therapeutic index (i.e. the therapeutic efficacy at tolerable dosage, or the ratio of toxic dose vs the therapeutic dose). Desoxyepothilone B, lacking the epoxide functionality, exhibited far superior therapeutic results *in vivo* as compared to the more potent EpoB. Similarly, the present therapeutic results for dEpoB in MX-1
30 xenografts were far better than those for EpoB, paclitaxel, doxorubicin, vinblastine or camptothecin. In addition, the effects of dEpo B on MCF-7/Adr xenografts were significantly better than those for paclitaxel, doxorubicin and camptothecin. In view of the finding that the epothilones have little or no cross-resistance against MDR tumor cells *in vitro*, the special therapeutic advantage of such compounds might be in their use against MDR-resistant tumors.

Novel Aldol Condensation with 2-Methyl-4-pentenal: Application to Preparation of Epothilone B and Desoxyepothilone B

Stereoselectivity poses a potential hindrance to enhancing access to multicomponent libraries. Nicolaou, K.C., et al., *J. Am. Chem. Soc.* **1997**, *119*, 7960; Nicolaou, K.C., et al., *J. Am. Chem. Soc.* **1997**, *119*, 7974. Nicolaou, K.C., et al., *Angew. Chem. Int. Ed. Engl.* **1997**, *36*, 2097. However, stereoselectivity holds the attraction that it allows for accumulation of substantial quantities of fully synthetic key epothilones of correct configuration. Comparable harvesting of needed amounts of material through the stereo-random olefin metathesis route (Yang, Z., Y., et al., *Angew. Chem. Int. Ed. Engl.* **1997**, *36*, 166; Nicolaou, K.C., et al., *Angew. Chem. Int. Ed. Engl.* **1997**, *36*, 525; Nicolaou, K.C., et al., *Nature* **1997**, *387*, 268; Nicolaou, K.C., et al., *J. Am. Chem. Soc.* **1997**, *119*, 7960; Nicolaou, K.C. et al., *J. Am. Chem. Soc.* **1997**, *119*, 7974; Nicolaou, K.C., et al., *Angew. Chem. Int. Ed. Engl.* **1996**, *35*, 2399. Schinzer, D., et al., *Angew. Chem. Int. Ed. Engl.* **1997**, *36*, 523; Meng, D., et al., *J. Am. Chem. Soc.* **1997**, *119*, 2733) would be virtually prohibitive. Biological studies in xenograft mice provided herein identified some significant toxicity problems with the highly potent epothilone B. Remarkably, *in vivo* studies in the intraperitoneal mode of injection demonstrate that the less potent 12,13-deoxyepothilone B is well tolerated and is virtually curative against a variety of xenograft tumors. Chou, T.-C., et al., *Proc. Nat'l Acad. Sci. USA* **1998**, 0000. Desoxyepothilone B has clinical advantages relative to paclitaxel, particularly as regards vulnerability to the phenomenon of multiple drug resistance. The preparative route disclosed herein retains the advantages of high stereoselectivity throughout, and provides an improved approach to the previously difficult C1-C11 domain. Figure 53 provides a global overview of the problem.

The route disclosed herein is based on four findings. The first is the ease of formation and the synthetic utility of the Z-lithium enolate (**48A**) readily produced from **59** as shown in Figure 61(A). In this easily obtained construct, the critical enolate of the ethyl ketone is fashioned in the context of a putative β,δ -diketoester ensemble embracing carbons 1-6 of the target (cf. structure **47**). The advantages of this direct approach for synthetic economy are apparent.

The second and most surprising finding undergirding this synthesis is that the sense of addition of enolate **48A** to readily available S-aldehyde **58** provides the desired C7-C8 *anti* relationship with good diastereofacial selectivity in conjunction with the expected C6-C7 *syn* relationship (by 1k-addition). C.H. Heathcock, in *Asymmetric Synth.* J.D. Morrison, ed., Academic Press, New York, **1984**, Vol. 3, p.111-212; see compound **49** and its stereoisomer. The stereochemistry of the minor diastereomer was presumed to be C7-C8 *syn*, but was not rigorously proven. This was based on precedent (Mori, I., et al., *J. Org. Chem.*, **1990**, *55*, 1114), assuming that this isomer arises from facial selectivity in the aldol reaction, not as a

- consequence of the *E*-enolate of **48A**. Those assignments also rely to varying extents on the Heathcock precedent. The 5.5:1 outcome for the diastereofacial selectivity of this aldol reaction is counter to expectations arising from the traditional models first advanced by Cram and Felkin. (For transition state models in diastereomeric carbonyl addition reactions see: D. J. Cram, F.A. Elhafez, *J. Am. Chem. Soc.* **1952**, *74*, 5828; D.J. Cram, K. R. Kopecky, *J. Am. Chem. Soc.* **1959**, *81*, 2748; J.W. Cornforth, R.H., et al., *J. Am. Chem. Soc.* **1959**, *81*, 112; G.J. Karabatsos, *J. Am. Chem. Soc.* **1967**, *89*, 1367; M. Cherest, H. Felkin, N. Prudent, *Tetrahedron Lett.* **1968**, 2199; N.T. Ahn, O. Eisenstein, *Nouv. J. Chem.* **1977**, *1*, 61; A.S. Cieplak, *J. Am. Chem. Soc.* **1981**, *103*, 4540; E.P. Lodge, C.H. Heathcock *J. Am. Chem. Soc.* **1987**, *109*, 2819.)
- 10 These extensively invoked formulations, which differ widely in their underlying conformational assumptions and stereochemical treatments, usually converge in terms of their predicted outcome.

- The high *anti:syn* diastereofacial ratio arises from a peculiar characteristic of aldehyde **58** and likely reflects the relationship of its vinyl and formyl groups. It is not, apparently the
- 15 result of a gross property of enolate **48A**. Indeed, the same enolate, with the benchmark aldehyde phenylpropanal **60a**, performs in the expected fashion (C.H. Heathcock in *Asymmetric Synth.* J.D. Morrison, ed., Academic Press, New York, **1984**, Vol. 3, p.111-212), yielding an 11:1 ratio of **61a:62a**. Furthermore, with aldehyde **60b**, the dihydro version of **58**, the C7 to C8 *anti:syn* (**61b:62b**) ratio drops to 1:1.3. Moreover, when the distance between the
- 20 vinyl and formyl groups is extended, as in **60c**, selectivity is also compromised. By contrast the phenyl and dimethylallyl analogs of **58** (**60d** and **60e**) bearing the same relationship of unsaturated groups as in **58**, exhibit good *anti*-antiselectivity (see products **61d** and **61e** as well as **62d** and **62e**). Also, aldehyde **60f**, a substrate known for its tendency to favor the *anti*-diastereofacial product (M.T. Reetz, *Angew. Chem. Int. Ed. Engl.* **1984**, *23*, 556) on the basis
- 25 of presumed chelation control, performs normally with enolate **48A** affording a 1:4 ratio of **61f:62f**.

- With respect to the impact of the strong *anti:syn* diastereofacial selectivity in the aldol reaction of **58** and **48A** on the overall efficiency of the synthesis, the rather favorable result in establishing the C7-C8 bond opened the possibility that the C1-C7 fragment could be entered
- 30 into the synthesis as an achiral block. Accordingly, it would be necessary to gain control over the eventual stereochemistry at C3. This subgoal was to be accomplished by the implementation of any asymmetric, reagent controlled Noyori reduction (*vide infra*). Noyori, R., et al., *J. Am. Chem. Soc.* **1987**, *109*, 5856; Taber, D.F., Silverbert, L., *Tetrahedron Lett.* **1991**, *32*, 4227; Ager, D.J., Laneman, S., *Tetrahedron Asymmetry* **1997**, *8*, 3327.

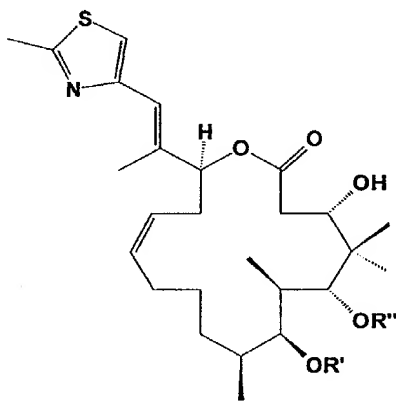
- 35 The third critical element was the finding that the key *B*-alkyl Suzuki merger which controls the geometry of the trisubstituted double bond can be conducted successfully even on the elaborate **51**, obtained from **49**. The cognate substrate for the Suzuki reaction was the

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previously described vinyl iodide, **51** (Su, D.-S., et al., *Angew. Chem. Int. Ed. Engl.* **1997**, 36, 757). The remarkable coupling step, afforded the Z-olefin **52A** and thence, **52** after removal of the C15 silyl protecting group (Figure 61(B)). The β,δ -diketo ester array in **52** responded well to asymmetric catalytic reduction under modified Noyori conditions (Taber, D., Silverbert, L.J., *Tetrahedron Lett.* **1991**, 32, 4227) to give the diol **53** (88%, >95:5). Strict regiochemical and diastereofacial control in the Noyori reduction was very dependent on the amount of acid present in the reaction. Without acid, the rate of reduction dropped off as well as the selectivity in the reduction. Further, the carbonyl at C-5 was never reduced under these conditions but was absolutely necessary for the reduction of the C-3 carbonyl. When C-5 was in the alcohol oxidation state, no reduction was seen. The conversion of **53** to desoxyepothilone B and thus epothilone B was accomplished by methodologies set forth herein. Balog, A., et al., *Angew. Chem. Int. Ed. Engl.* **1996**, 35, 2801; Su, D.-S., et al., *Angew. Chem. Int. Ed. Engl.* **1997**, 36, 757; Meng, D., et al., *J. Am. Chem. Soc.* **1997**, 119, 10073.

15 Biological Results

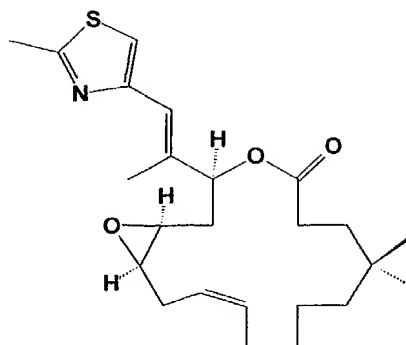
In the tables which follow, model system I is desoxyepothilone. Model system 2 has the structure:



wherein R' and R'' are H.

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Model system 3 has the structure:



As shown in Table 2A, CCRF-CEM is the parent cell line. CCRF-CEM/VBL (MDR cell line) is 1143-fold resistant to Taxol®. CCRF-CEM/VM (Topo II mutated cell line) only 1.3-fold resistant to Taxol®.

- 5 In terms of relative potency, synthetic Epothilone is roughly the same as natural Epothilone A. For CCRF-CEM cells, the ordering is:
Taxol® ≈ Epothilone A > Desoxy Epothilone A >> Triol Analog >> Model System I

For CCRF-CEM/VBL, the relative potency ordering is:

Desoxy Epothilone A ≥ Epothilone A >> Taxol® > Triol Analog > Model System I

- 10 For CCRF-CEM/VM, the relative potency ordering is:

Taxol® ≈ Epothilone A > Desoxy Epothilone A >> Model System I > Triol Analog

It is concluded that CCRF-CEM/VM cells are collaterally sensitive to certain epothilone compounds.

Table 2. Relative Efficacy of Epothilone Compound Against HumanLeukemic CCRF-CEM Cell Growth and Against CCRF-CEM MDR Sublines Resistant to Taxol® or Etoposide

COMPOUND	IC ₅₀ in μ M		
	CCRF-CEM	CCRF-CEM/VLB	CCRF-CEM/VM-1
EPOTHILONE A NATURAL	0.0035	0.0272	0.0034
EPOTHILONE A SYNTHETIC	0.0029	0.0203	0.0034
MODEL SYSTEM I [3]	271.7	22.38	11.59
TRIOL ANALOG [2]	14.23	6.28	43.93
DESOXY EPOTHILONE [1]	0.002	0.012	0.013
Taxol®	0.0023	2.63	0.0030
VINBLASTINE	0.00068	0.4652	0.00068
VP-16 (ETOPOSIDE)	0.2209	7.388	34.51

Table 2A. Relative Potency of Epothilone Compounds Against Human Leukemic CCRF Sublines

COMPOUND	CCRF-CEM (Parent Cell Line)	CCRF-CEM/VBL (MDR Cell Line) (Taxol® Resistant)-(1143 fold) (Vinblastine Resistant)	CCRF-CEM/VL ₁ (Topo II gene mutated cell line) (Taxol® Sensitive) (VP-16 resistant)
	IC ₅₀ [IC ₅₀ (μM) relative to (A) Epothilone A]	IC ₅₀ [IC ₅₀ (μM) relative to (B) Epothilone A (B)/(A)]	IC ₅₀ [IC ₅₀ (μM) relative to (C) Epothilone A (C)/(A)]
Taxol®	0.0023 [0.72]	2.63 [109.6] (1143) ^a	0.0030 [0.88] (1.30) ^a
MODEL SYSTEM I	271.7 [84906]	22.38 [932.5] (0.082) ^b	11.59 [3409] (0.043) ^b
TRIAL ANALOG	14.23 [4447]	6.28 [261.7] (0.44) ^b	43.93 [12920] (3.09) ^a
DESOXYEPO- THILONE A	0.022 [6.9]	0.012 [0.5] (0.55) ^b	0.013 [3.82] (0.59) ^b
EPOTHILONE A	0.0032 [1]	0.024 [1] (7.5) ^a	0.0034 [1] (1.06) ^a

a. (B)/(A) or (C)/(A) ratio > 1 indicates fold of resistance when compared with the parent cell line. b. (B)/(A) or (C)/(A) ratio < 1 indicates fold of collateral sensitization when compared with the parent cell line.

Table 3. Relative Efficacy of Epothilone Compounds Against The DC-3F Hamster Lung Cell Growth and Against DC-3F MDR Sublines Resistant Actinomycin D

COMPOUNDS	IC ₅₀ in μ M		
	DC-3F	DC-3F/ADII	DC-3F/ADX
EPOTHILONE A NATURAL	0.00368	0.01241	0.0533
EPOTHILONE A SYNTHETIC	0.00354	0.0132	0.070
MODEL SYSTEM I [3]	9.52	3.004	0.972
TRIOL ANALOG [2]	10.32	4.60	4.814
DESOXY EPOTHILONE [1]	0.01061	0.0198	0.042
Taxol®	0.09469	3.205	31.98
VINBLASTINE	0.00265	0.0789	1.074
VP-16 (Etoposide)	0.03386	0.632	12.06
ACTINOMYCIN-D	0.000058 (0.05816nm)	0.0082	0.486

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Concerning Table 3, experiments were carried out using the cell lines DC-3F (parent hamster lung cells), DC-3F/ADII (moderate multidrug-resistant (MDR) cells) and DC-3F/ADX (very strong MDR cells).

The relative potency of the compounds are as follows:

DC-3F: Actinomycin D > Vinblastine \geq Epothilone A (0.0036 μ M) > Desoxy
epothilone > VP-16 > Taxol® (0.09 μ M) > Model system I and triol
analog

DC-3F/ADX: Desoxyepothilone \geq Epothilone A (0.06 μ M) > Actinomycin D
> Model system I > Vinblastine > triol analog > viablastine
> Taxol® (32.0 μ M)

DC-3F/ADX cells (8379-fold resistant to actinomycin D) are >338 fold (ca. 8379 fold)
resistant to Taxol®, VP-16, Vinblastine and Actinomycin D but <20 fold
resistant to epothilone compounds.

In general, these results are similar to those for CCRF-CEM cells.

Table 4. Three Drug Combination Analysis

(Based on the Mutually Exclusive Assumption – Classical Isobologram Method)

Drug A: EPOTHILONE B (#8) (μM)Drug B: Taxol® (μM)Drug C: VINBLASTINE (μM)

Conditions:

CCRF-CEM, 3 DRUG COMBINATION, RATIO (A:B:C: 1:5:1); EPOTHILONE + Taxol® + VINBLASTINE; EXPOSURE TIME 72 HRS; XTT ASSAY.

Drug	Combination Index * Values at:					Parameters		
	ED50	ED75	ED90	ED95	Dm (IC ₅₀) (μM)	m	r	
A					-00061	1.71561	.98327	
B					-00109	2.14723	.98845	
C					-00061	1.76186	.9919	
A+B	1.51545	1.38631	1.27199	1.20162	-00146	2.41547	.97168	
B+C	1.43243	1.33032	1.23834	1.18091	.00138	2.35755	.95695	
A+C	.74395	.68314	.62734	.59204	.00045	2.0098	.96232	
A+B + C	1.37365	1.32001	1.27285	1.24412	.00122	2.11202	.93639	

VBL → microtubule depolymerization

Taxol® → microtubule polymerization

Epo-B → microtubule polymerization

Epothilone B and Taxol® have a similar mechanism of action (polymerization) but Epothilone B synergizes VBL whereas Taxol® antagonizes VBL.

Taxol® + VBL → Antagonism

EpoB + Taxol® → Antagonism

EpoB + VBL → Synergism

EpoB + Taxol® + VBL → Antagonism

*Combination index values < 1, = 1, and > 1 indicate synergism, additive effect, and antagonism, respectively.

Table 5. Relative cytotoxicity of epothilone compounds *in vitro*.

Compounds	IC ₅₀ in μ M			
	CCRF-CEM	CCRF-CEM/VLB	CCRF-CEM/M-1	CCRF-CEM/M-1
VINBLASTINE	**** 0.0008	0.44	0.00049	0.00049
	0.0006 (0.00063	0.221 (0.332	0.00039	(0.00041
	0.0005 \pm 0.00008)	0.336 \pm 0.063	0.00036	\pm 0.00004)
		(52.7X) [§]		(0.7X)
VP-16	0.259	6.02	35.05	35.05
	0.323 (0.293	9.20 (10.33	42.24	(34.39
	0.296 \pm 0.019)	15.76 \pm 2.87)	25.89	\pm 4.73)
		(35.3X)		(117.4X)
Taxol®	*** 0.0021	4.14	0.0066	0.0066
#17	*	0.090	0.254	0.254
#18		1157.6	> > 1	> > 1
#19		0.959	> > 1	> > 1
#20	*	0.030	0.049	0.049
#21		-	-	-
#22	*	0.098	0.146	0.146
#23		-	-	-
#24	***	0.0078	0.053	0.053
#25	*	0.021	0.077	0.077
#26	*	0.055	0.197	0.197
#27	***	0.0010	0.0072	0.0072
Epothilone A (Syn)	***	0.0021	0.015	0.015
Epothilone B (Syn)	***	0.00042	0.0017	0.0017

* Number of asterisks denotes relative potency.

§ Number in parentheses indicates relative resistance (fold) when compared with parent cell line.

Table 6. Relative potency of epothilone compounds *in vitro*.

Compounds		IC ₅₀ in μ M		
		CCRF-CEM	CCRF-CEM/VBL	CCRF-CEM/VM-1
Desoxy Epo. A	1	* 0.022	0.012	0.013
	2	14.23	6.28	43.93
	3	271.7	22.38	11.59
	4	2.119	43.01	2.76
	5	> 20	35.19	98.04
Trans- A	6	0.052	0.035	0.111
	7	7.36	9.82	9.65
Syn-Epo.-B	8	**** 0.00082	0.0029	0.0044
Natural B	9	**** 0.00044	0.0026	0.0018
Desoxy Epo. B	10	*** 0.0095	0.017	0.014
Trans. Epo. B	11	* 0.090	0.262	0.094
	12	0.794	> 5	> 5
	13	11.53	5.63	14.46
8-desmethyl desoxy-Epo	14	5.42	5.75	6.29
8-desmethyl Mix-cis Epo	15	0.96	5.95	2.55
8-desmethyl β -Epo	15	0.439	2.47	0.764
8-demethyl α -Epo	16	7.47	16.48	0.976
EPOTHILONE A (Natural)		*** 0.0024 (0.0027 0.0031 \pm 0.0003)	0.0211 (0.020 0.0189 \pm 0.001) (7.4X)	0.006 (0.00613 0.00625 \pm 0.0001) (2.3X)
EPOTHILONE B (Natural)		**** 0.00017	0.0017 (7.0X)	0.00077
EPOTHILONE B (Synthetic)		0.00055	0.0031	0.0018
EPOTHILONE B (Synthetic, larger quantity synthesis) (25.9mg)		(0.00035 \pm 0.0003)	(0.00213 \pm 0.00055)	(0.00126 \pm 0.0003)
		0.00033	0.0021 (6.1X)	0.0012 (3.6X)

Table 7. Relative cytotoxicity of epothilone compounds *in vitro*.

	IC ₅₀	
	CEM	CEM/VBL
epothilone A	0.0029 μ M	0.0203 μ M
desoxyepothilone	0.022	0.012
2	14.2	6.28
3	271.7	22.4
4	2.1	43.8
5	> 20	35.2
6	0.052	0.035
7	7.4	9.8
synthetic epothilone B	0.00082	0.00293
natural epothilone B	0.00044	0.00263
desoxyepothilone B	0.0095	0.0169
11	0.090	0.262
12	0.794	> 5
13	11.53	5.63
11	5.42	5.75
15	0.439	2.47
19	7.47	16.48
17	0.090	0.254
18	1157.6	> > 1
19	0.959	> > 1
20	0.090	0.049
21	Not Available	-
22	0.098	0.146
23	Not Available	-
24	0.0078	0.053
25	0.0212	0.077
26	0.0545	0.197
27	0.0010	0.0072

Table 8. Chemotherapeutic Effect of Epothilone B, Taxol® & Vinblastine in CB-17 Scid Mice Bearing Human CCRF-CEM and CCRF-CEM/VBL Xenograft¹

Tumor	Drug ²	Dose	Average weight change					Average tumor volume				
			Day 0	Day 7	Day 12	Day 17	Day 22	Day 7	Day 12	Day 17	Day 22	
CCRF-CEM	0	0	24.4	+0.2	+0.4	+0.1	+0.5	1.0 ³	1.00	1.00	1.00	
		Epo B	24.7 25.0	-0.1 +0.1	-0.7 -1.5	-1.4 -2.4	+0.3 +0.1	1.0 1.0	0.53 0.46	0.48 0.35	0.46 0.43	
	Taxol®	2.0 4.0	25.1 25.1	-0.1 -0.2	-1.1 -1.7	-1.5 -1.9	-0.3 -0.3	1.0 1.0	0.39 0.37	0.29 0.23	0.28 0.19	
		VBL	0.2	25.9	+0.2	-0.8	-1.5	-0.3	1.0	0.45	0.25	0.29
	CCRF-CEM/VBL	0	0	26.3	-0.3	+0.1	-0.3	+0.4	1.0	1.00	1.00	1.00
			Epo B	0.7 1.0 ⁶	25.8 26.0	+0.1 -0.2	-0.7 -1.3	-1.0 -2.1	-0.2 -0.5	1.0 1.0	0.32 0.41	0.40 0.27
Taxol®		2.0 4.0	26.1 26.0	0 0	-0.9 -1.4	-1.5 -1.6	-0.1 -0.9	1.0 1.0	0.60 0.79	0.58 0.55	0.70 0.41	
		VBL	0.2 0.4	25.9 25.9	-0.3 0	-0.8 -1.2	-1.4 -1.8	-0.3 -0.5	1.0 1.0	0.86 1.02	0.66 0.57	0.67 0.62

1. CCRF-CEM and CCRF-CEM/VBL tumor tissue 50ul/mouse implanted S.C. on day 0, Treatments i.p., QD on day 7, 8, 9, 10, 14 and 15. There were seven CB-17 scid male mice in each dose group and control.

2. Epo B, epothilone B; VBL, vinblastine.

3. The tumor volumes for each group on day 7 was about 1 mm³. The average volumes of CCRF-CEM control group on day 12, 17 and 22 were 19, 76 and 171 mm³, and of CCRF-CEM/VBL control group were 35, 107 and 278 mm³, respectively.

4. Two mice died of drug toxicity on day 19 & 20.

5. Three mice died of drug toxicity on day 18, 19 and 21.

6. One mouse died of drug toxicity on day 17.

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In summary, epothilones and Taxol® have similar modes of action by stabilizing polymerization of microtubules. However, epothilones and Taxol® have distinct novel chemical structures.

- MDR cells are 1500-fold more resistant to Taxol® (CCRF-CEM/VBL cells),
 5 epothilone A showed only 8-fold resistance and epothilone B showed only 5-fold resistance. For CCRF-CEM cells, Epo B is 6-fold more potent than Epo A and 10-fold more potent than Taxol®. Desoxyepothilone B and compd #24 are only 3-4-fold less potent than Taxol® and compound #27 is > 2-fold more potent than Taxol®. Finally, Taxol® and vinblastine showed
 10 antagonism against CCRF-CEM tumor cells, whereas the combination of Epo B + vinblastine showed synergism.

Relative Cytotoxicity of Epothilones against Human Leukemic Cells *in Vitro* is in the order as follows:

CCRF-CEM Leukemic Cells

- 15 Epo B (IC_{50} = 0.00035 μ M; Rel. Value = 1) > VBL (0.00063; 1/1.8) > #27 (0.0010; 1/2.9) > Taxol® (0.0021; 1/6) > Epo A (0.0027; 1/7.7) > #24 (0.0078; 1/22.3) > #10 (0.0095; 1/27.1) > #25 (0.021; 1/60) > #1 (0.022; 1/62.8) > #20 (0.030; 1/85.7) > #6 (0.052; 1/149) > #26 (0.055; 1/157) > #17 (0.090; 1/257) > VP-16 (0.29; 1/8.29) > #15 (0.44; 1/1257) > #19 (0.96; 1/2943)

CCRF-CEM/VBL MDR Leukemic Cells

- 20 Epo B (0.0021; 1/6* [1]**) > #27 (0.0072; 1/20.6) > #1 (0.012; 1/34.3) > #10 (0.017; 1/48.6) > Epo A (0.020; 1/57.1 [1/9.5]) > #6 (0.035) > #20 (0.049) > #24 (0.053) > #25 (0.077) > #22 (0.146) > #26 (0.197) > #17 (0.254) > #11 (0.262) > VBL (0.332; 1/948.6 [1/158.1]) > Taxol® (4.14; 1/11828 [1/1971.4]) > VP-16 (10.33; 1/29514 [1/4919])

*Potency in parentheses is relative to Epo B in CCRF-CEM cells.

- 25 **Potency in square brackets is relative to Epo B in CCRF-CEM/VBL MDR cells.

- As shown in Table 9, treatment of MX-1 xenograft-bearing nude mice with desoxyepothilone
 30 B (35mg/kg, 0/10 lethality), Taxol® (5mg/kg, 2/10 lethality; 10mg/kg, 2/6 lethality) and adriamycin (2mg/kg, 1/10 lethality; 3mg/kg, 4/6 lethality) every other day, i.p. beginning day 8 for 5 doses resulted in a far better therapeutic effect for desoxyepothilone B at 35 mg/kg than for Taxol® at 5 mg/kg and adrimycin at 2mg/kg with tumor volume reduction of 98%, 53% and 28%, respectively. For the desoxyepothilone B-treated group, 3 out of 10 mice were
 35 found with tumor non-detectable on day 18. (See Fig. 46)

Extended treatment with desoxyepothilone B (40mg/kg, i.p.) beginning day 18 every other day for 5 more doses resulted in 5 out of 10 mice with tumor disappearing on day 28 (or day 31). See Table 10. By contrast, the extended treatment with Taxol® at 5mg/kg for five more doses resulted in continued tumor growth at a moderate rate, and 2 out of 10

mice died of toxicity.

Toxicity studies with daily i.p. doses of desoxyepothilone B (25mg/kg, a very effective therapeutic dose as indicated in earlier experiments) for 4 days to six mice resulted in no reduction in average body weight. (Table 13; Fig. 47) By contrast, epothilone B
5 (0.6mg/kg, i.p.) for 4 days to eight mice resulted in 33% reduction in average body weight; all eight mice died of toxicity between day 5 and day 7.

As evident from Table 15, desoxyepothilone B performs significantly better than Taxol®, vinblastine, adriamycin and camptothecin against MDR tumor xenografts (human mammary adenocarcinoma MCF-7/Adr xenografts). This drug-resistant tumor grows very
10 aggressively and is refractory to Taxol® and adriamycin at half their lethal doses. Taxol® at 6mg/kg i.p. Q2Dx5 reduced tumor size only 10% while adriamycin resulted in only a 22% reduction on day 17. Whereas, desoxyepothilone B at 35 mg/kg reduced tumor size by 66% on day 17 and yet showed no reduction in body weight or apparent toxicity. Even at the LD₅₀ dosage for Taxol® (12mg/kg) or adriamycin (3mg/kg), desoxyepothilone B still performed
15 more effectively. By comparison, camptothecin at 1.5 and 3.0 mg/kg reduced tumor size by 28% and 57%, respectively. Overall, in comparison with the four important anticancer drugs in current use, i.e., Taxol®, adriamycin, vinblastine and camptothecin, desoxyepothilone B showed superior chemotherapeutic effect against MDR xenografts.

20

In vivo therapeutic results in nude mice for dEpoB and Taxol® are reported in Tables 19-21. As shown in the Tables, 6hr i.v. infusion via tail vein provided a good therapeutic profile with remarkably low toxicity.

For mammary MX-1 xenograft (non-MDR), desoxyepothilone B was as effective as
25 Taxol®. Both drugs were administered by 6hr i.v. infusion and both achieved full cure.

For the MDR-mammary MCF-7/Adr xenograft, the therapeutic effect of desoxyepothilone B was far better than Taxol®, although Q2Dx5 did not achieve a cure.

For CCRF-CEM/Taxol® (57-fold resistant to Taxol® *in vitro*, in-house developed cell line), Taxol® did not show significant therapeutic effect in this nude mice xenograft whereas
30 desoxyepothilone B achieved a full cure.

Prolonged (6 hr.) i.v. infusion allowed higher doses (e.g., 30 mg/kg, Q2Dx5) to be administered (without lethality) than i.v. bolus injection of desoxyepothilone B, and yet reduced drug toxicity.

Accordingly, the present inventors have found desoxyepothilone B to have excellent
35 properties for therapeutic application as an MDR agent and moreover as a general anticancer agent.

Table 9. Therapeutic Effect of Desoxyepothilone B, Taxol®, and Adriamycin in Nude Mice Bearing Human MX-1 Xenograft^a

Drug	Dose (mg/kg)	Average Body Weight Change (g)								Average Tumor Volume (T/C)				Tumor		# Mice Died
		Day 8	10	12	14	16	18	+1.3	+1.8	Day 10	12	14	16	18	Disappearance	
Control	0	24.6	-0.1	+1.0	+1.0	+1.3	+1.8	-1.7	-1.6	0.42	0.28	0.07	0.04	0.02	0/10	0/10
Desoxyepothilone B	35	23.0	-0.1	+0.7	-0.3	-1.7	-1.6	-1.7	-1.6	0.58	0.36	0.34	0.42	0.47	2/10	0/10
Taxol®	5	24.0	-1.3	-0.8	-1.4	-1.9	-1.8	-1.9	-1.8	0.85	0.40	0.21	0.20	0.12	2/6	1/6
Adriamycin	10	24.3	-1.0	-1.0	-2.3	-3.5	-3.8	-3.5	-3.8	0.94	0.88	1.05	0.69	0.72	1/10	0/10
	2 ^b 3 ^c	23.9 22.4	+0.3 +1.3	0 -0.2	-1.4 -1.5	-1.9 -2.1	-2.0 -2.3	-1.9 -2.3	-2.0 -2.3	0.72	0.54	0.56	0.51	0.36	4/6	0/6

a. MX-1 tissue 100 μ l/mouse was implanted s.c on day 0. Every other day i.p. treatments were given on day 8, 10, 12, 14 and 16.

15 The average tumor volume of control group on day 10, 12, 14, 16 and 18 were 78, 151, 372, 739 and 1257 mm³, respectively.

b. One mouse died of toxicity on day 22.

c. Four mice died of toxicity on day 24.

Table 10. Extended Experiment of Desoxyepothilone B, Taxol®, Cisplatin and Cyclophosphamide in Nude Mice Bearing Human MX-1 Xenograft^a

Drug	Dose (mg/kg)	Average Body Weight Change (g)				Tumor Disappearance				Average Tumor Disappearance Duration (Day)	# Died		
Desoxyepo B	40	Day 8	20	22	24	26	28	Day 20	22	24	26	28	
		23.0	-1.7	-2.4	-2.4	-1.4	-1.2	2/10 ^b	2/10	3/10	5/10	5/10	44(5/10)
Taxol®	5	24.0	-1.6	-0.3	+0.1	-0.6	-0.4	0/10	0/10	0/10	0/10	0/10	2/10
	10	No extended test						1/6 on day 16					Reappeared on day 38

- a. Extended experiment was carried out after 5 times injection (on day 8, 10, 12, 14 and 16). Every other day i.p. treatments were given continuously: Desoxyepothilone B and Taxol® on day 18, 20, 22, 24 and 26; control group mice were sacrificed.
b. One of the mice tumor reappeared on day 20.

Table 11. Toxicity of Epothilone B and Desoxyepothilone B in normal nude mice.

Group	Dose and Schedule (mg/kg)	Number of mice	Died	Disappearance
Control		4	0	
Epothilone B ^a	0.6 QD x 4	8	8	
Desoxyepothilone B	25 QD x 4	6	0	

- a. Mice died of toxicity on day 5, 6, 7, 7, 7, 7, 7

Table 12. Therapeutic Effect of Etoposide B, Desoxyeposide B and Taxol® in B6D2F₁ Mice Bearing B16 Melanoma^a

Drug	Dose (mg/kg)	Average Weight Change (g)						Average Tumor Volume (T/C)				# Mice Died
		Day 0	3	5	7	9	11	Day 5	7	9	11	
Control	0	26.5	-0.2	0	-0.2	0	+1.0	1.00	1.00	1.00	1.00	0/15
Etoposide B	0.4 QDx6 ^b	27.1	-0.2	-0.6	-1.1	-3.4	-3.9	1.08	1.07	1.27	1.07	1/8
	0.8 QDx5 ^c	27.0	0	-0.8	-3.1	-4.7	-4.7	0.57	0.89	0.46	0.21	5/8
Desoxyeposide B	10 QDx8	27.0	-0.7	-0.9	-1.1	-1.5	-0.3	0.23	0.22	0.51	0.28	0/6
	20 QD1-4,7-8	26.9	-1.3	-2.2	-1.3	-1.6	-0.8	0.59	0.63	0.58	0.33	0/6
Taxol®	4 QDx8	26.7	+0.1	+0.2	+0.3	+0.4	+0.8	0.62	0.39	0.56	0.51	0/8
	6.5 QDx8	26.7	+0.1	+0.3	+0.3	+0.4	+1.7	0.19	0.43	0.20	0.54	0/8

a. B16 melanoma cells 1.2 x 10⁶/mouse was implanted S.C. on day 0. Daily treatments start on day 1 after inoculation.

Number of mice in each group: Control, 15; Etoposide B, 8; Desoxyeposide B, 5 and Taxol®, 8. The average tumor volume of control group on day 5, 7, 9 and 11 were 16, 138, 436 and 1207 mm³, respectively. See Figs. 44(a) and (b).

b. One mouse died of toxicity on day 10.

c. Five mice died of toxicity on day 8, 10, 10, 11, 12. One moribund mouse was sacrificed for toxicological examinations on day 11.

Table 13. Therapeutic Effect of Desoxyepothilone B, Epothilone B, Taxol® and Vinblastine in Nude Mice Bearing Human MX-1 Xenograft^a.

Drug	Dose (mg/kg)	Average Body Weight Change (g)						Average Tumor Volume (T/C)						Note
		Day 7	11	13	15	17		Day 11	13	15	17			
Control died		27.9	+0.8	+1.1	+1.9	+0.6		1.00	1.00	1.00	1.00		0/8	
Desoxyepothilone B	15	27.1	+0.8	+1.1	+1.6	+1.5		0.65	0.46	0.49	0.41		0/6 died	
	25 ^b	27.0	+0.4	+0.7	+1.0	+0.7		0.38	0.11	0.05	0.04		0/6 died (1/6 cured on day 35)	
Epothilone B	0.3	26.9	+0.5	+0.4	-0.3	-1.2		1.00	0.71	0.71	0.84		0/7 died	
	0.6 ^c	27.4	-0.3	-1.3	-2.1	-2.1		1.08	0.73	0.81	0.74		3/7 died	
Taxol®	5	26.9	-0.1	+0.4	+1.1	+1.2		0.54	0.46	0.40	0.45		0/7 died	
	10 ^d	27.6	-2.7	-1.1	-0.3	+2.2		0.43	0.37	0.12	0.11		4/7 died	
Vinblastine	0.2	25.7	+0.6	+1.4	+2.3	+2.9		0.65	0.54	0.56	0.88		0/7 died	
	0.4 ^e	26.4	+0.8	+0.5	+1.9	+2.1		0.80	0.56	0.83	0.88		1/7 died	

- a. MX-1 tissue 50 μ l/mouse was implanted s.c. on day 0. Every other day i.p. treatments were given on day 7, 9, 11, 13 and 15. Number of mice in each group: Control, 8; Desoxyepothilone B, 6; Epothilone B, 7; Taxol®, 7 and Vinblastine, 7. The average tumor volume of control group on day 11, 13, 15 and 17 were 386, 915, 1390 and 1903 mm³, respectively. See Fig. 45.
- b. One out of six mice with no detectable tumor on day 35.
- c. Three mice died of drug toxicity on day 17. Every other day i.p. treatments were given except day 15.
- d. Four mice died of drug toxicity on day 13, 13, 13, 15.
- e. One mouse died of drug toxicity on day 15.

Table 14. Toxicity of Hematology and Chemistry of Desoxyepothilone B, and Taxol® in Nude Mice Bearing Human MX-1 Xenograft^a

Drug	Dose (mg/kg ip)	Hematology ^b				Chemistry ^b		
		WBC	Lymph (%)	RBC	PLT	GOT	GPT	
		Total (10 ³ /mm ³)	Neutrophils (%)	(10 ³ /mm ³)	(10 ⁶ /mm ³)	(U/L)	(U/L)	(U/L)
Control		12.9	38	61	8.1	800 (n=4)	203	45 (n=4)
Desoxyepo- thilone B	25 and 35 ^c	11.8	48	48	8.4	700 (n=6)	296	55 (n=3)
Taxol®	5 and 6 ^d	10.9	51	48	6.1	1083 (n=5)	438	79 (n=5)
Normal range ^e		6.91-12.9	8.25-40.8	62-90	10.2-12.0	190-340	260	138.7

a. Minced MX-1 tumor tissue 50 μ l/mouse was implanted s.c. on day 0.

b. All assays were determined on day 30; averaged values were given.

c. Desoxyepothilone B 25 mg/kg was given i.p. on day 7, 9, 11, 13, 15; 35mg/kg on day 17, 19, 23, 24, 25.

d. Taxol® 5mg/kg was given i.p. on day 7, 9, 11, 13, 15; 6mg/kg on day 17, 19, 23, 24, 25.

e. Normal ranges are for wild type deer mice and C₃/HeJ mice (obtained from clinical, biochemical and hematological Reference values in *Normal Experimental Animals*, Brijm Mitruka, ed., Masson Publishing USA, Inc., N.Y., 1977, and from *Clinical Chemistry of Laboratory Animals*, Weter F. Loeb, ed., Pergamon Press, 1989)

Table 15. Therapeutic Effect of Desoxyepothilone B, Taxol®, Adriamycin, and Camptothecin in Nude Mice Bearing MDR Human MCF-7/Adr Tumor.

Drug	Dose (mg/kg)	Average Body Weight Change (g)						Average Tumor Volume (T/C)					
		Day 8	11	13	15	17		Day 11	13	15	17		Died
Control	0	25.0	+2.0	+2.6	+3.1	+3.7		1.00	1.00	1.00	1.00		0/8
DesoxyEpoB	35	25.0	+0.3	+0.7	+0.6	+0.8		0.31	0.27	0.30	0.34		0/8
Taxol®	6	25.3	+1.7	+1.8	+0.8	+0.9		0.57	0.66	0.85	0.90		0/8
	12	24.5	+0.7	-1.3	-2.4	0		0.50	0.51	0.32	0.40		3/6
Adriamycin	1.8	25.6	+0.2	-0.4	-0.6	-0.4		0.70	0.68	0.84	0.78		0/8
	3	24.6	+0.5	-1.5	-3.2	-1.6		0.66	0.83	0.57	0.53		3/6
Camptothecin	1.5	24.4	+1.1	+0.9	+1.7	+1.4		1.08	0.72	0.61	0.72		0/8
	3.0	24.5	-0.6	-0.4	-0.8	-0.9		0.95	0.76	0.61	0.43		0/6

a. MCF-7/Adr cell 3×10^6 /mouse was implanted s.c. on day 0. Every other day i.p. treatments were given on day 8, 10, 12, 14 and 16. The average tumor volume of control group on day 11, 13, 15 and 17 were 392, 919, 1499 and 2372mm³, respectively.

Table 16. Extended Experiment of Desoxyepothilone B, Taxol® in Nude Mice Bearing Human MX-1 Xenograft^a

Drug	Dose (mg/kg)	Average Body Weight Change (g)							Tumor Disappearance					Average Tumor Disappearance					Died
		Day 8	20	22	24	26	28	Day 20	22	24	26	28	Day 20	22	24	26	28		
Desoxyepo B	40	23.0	-1.7	-2.4	-2.4	-1.4	-1.2	2.10 ^b	2/10	3/10	5/10	5/10	44 (5/10)	0/10	0/10	0/10	0/10	0/10	
Taxol®	5	24.0	-1.6	-0.3	+0.1	-0.6	-0.4	0/10	0/10	0/10	0/10	0/10	0/10	0/10	0/10	0/10	2/10		
	10	No Extended Test							1/6 on day 16,					Reappear on day 38					2/6 _(0/6)

- a. Extended experiment was going on after 5 times injection (on day 8, 10, 12, 14 and 16). Every other day i.p. treatments were given continuously: Desoxyepothilone B and Taxol® on day 18, 20, 22, 24 and 26; Control group mice were sacrificed.
- b. In one of the mice, a tumor reappeared on day 20.

As evident from Table 16, extended treatment of nude mice bearing human MX-1 xenografts with desoxyepothilone B results in complete tumor disappearance, with no mortality in any test animals. In conclusion, treatment with desoxyepothilone B shows remarkable specificity with respect to tumor toxicity, but very low normal cell toxicity.

Table 17. Therapeutic Effects of Desoxyepothilone B, Taxol® in Nude Mice Bearing MX-1 Xenograft.

		Treatment										Schedule										# Died of toxicity 0/10	
		35mg/kg on day					40mg/kg on day					No Treatment											
		8	10	12	14	16	18	20	22	24	26	28	30	35	40	45	47	50	60				
		8	10	12	14	16	18	20	22	24	26	28	30	35	40	45	47	50	60				
CONTROL																							
Day		8	10	12	14	16	18	20	22	24	26	28	30	35	40	45	47	50	60				
Tumor Size (mm ³)		19 ±2	78 ±8	151 ±15	372 ±55	739 ±123	1257 ±184	1991 ±331	Sacrificed (n = 10)														
DESOXYEPOTHILONE B																							
Dose		35mg/kg on day					40mg/kg on day					No Treatment											
Schedule		8	10	12	14	16	18	20	22	24	26	28	30	35	40	45	47	50	60				
Tumor Size		8	10	12	14	16	18	20	22	24	26	28	30	35	40	45	47	50	60				
Mouse 1		15	15	40	40	15	32	30	30	30	30	0	0	0	0	0	24	S*	—				
Mouse 2		23	23	15	15	15	15	30	48	48	0	30	48	900	1200	600	600	S	—				
Mouse 3		15	60	90	105	105	126	96	150	180	0	48	64	600	600	600	600	S	—				
Mouse 4		21	38	38	0	0	10	8	8	8	8	0	0	0	0	0	0	0	0				
Mouse 5		12	23	50	12	0	4	0	0	0	0	0	0	0	0	0	0	0	0				
Mouse 6		15	40	32	8	8	8	8	12	12	12	12	30	120	120	120	120	S	—				
Mouse 7		21	30	15	15	8	8	8	8	8	8	8	8	180	280	280	280	S	—				
Mouse 8		20	48	70	15	15	8	8	0	0	0	0	0	0	0	0	8	S	—				
Mouse 9		25	50	40	15	8	0	0	0	0	0	0	0	0	0	0	0	4	4				
Mouse 10		20	38	38	38	38	25	25	25	0	0	15	15	100	100	100	100	S	—				
Taxol®																							
Dose		5mg/kg on day					5mg/kg on day																
Schedule		8	10	12	14	16	18	20	22	24	26	28	30	35	40	45	47	50	60				
Day		8	10	12	14	16	18	20	22	24	26	28	30	35	40	45	47	50	60				
Tumor Size		17 ±2	45 ±7	54 ±13	128 ±42	311 ±115	596 ±151	1114 ±346	1930 ±569	2285 ±597	S	(n = 10)								Experiment ended			
		Extended studies										Extended observations								Experiment ended			

*S: Sacrificed due to tumor burden

Table 18. Toxicity of Epothilone B and Desoxyepothilone B in normal nude mice

Group	Dose and Schedule (mg/kg)	Number of mice	Died
Control		4	0
Epothilone B ^a	0.6 QD x 4	8	8
Desoxyepothilone B	25 QD x 4	6	0

a. Mice died of toxicity on day, 5,6,6,7,7,7,7

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Table 19. Therapeutic effects of desoxyepothilone B (dEpo B) and Taxol® in nude mice bearing MX-1 xenograft^a.

Drugs	Dose (mg/kg)	Route ^b i.v.	Average Body Weight (g)					Average Tumor Size (T/C)				Tumor Disappearance
			Day 8	14	16	18	20	Day 14	16	18	20	
Control	0		30.2	+0.8	+1.7	+2.6	+3.2	1.00	1.00	1.00	1.00	0/5
dEpo B	30	Q2Dx5	30.3	-2.7	-4.0	-4.5	-6.8	0.19	0.10	0.03	TD ^c	3/3
Taxol®	15	Q2Dx5	30.8	0	-1.1	-1.6	-1.4	0.06	0.01	TD	TD	4/4
	24	Q2Dx5	28.5	-4.8	-5.3	-6.0	-6.2	0.03	TD	TD	TD	4/4

^a MX-1 human mammary carcinoma tissue 50 µg was implanted s.c. into mice on day 0. Every other day i.v. infusion were given on day 8, 10, 12, 14 and 16. The average tumor volume of control group on day 14, 16, 18 and 20 were 170 ± 10, 246 ± 29, 345 ± 42 and 529 ± 65 mm³ (mean "SEM"), respectively.

^b The i.v. infusion was for 6 hrs. The vehicle used was in 100 FI (Cremophor + EtOH = 1:1) + 4ml saline.

^c TD: Tumor disappearance.

Table 20. Therapeutic effects of desoxyepoB (dEpo B) and Taxol® in nude mice bearing MCF-7 Adr xenograft^a

Drug	Dose (mg/kg)	Route ^b i.v.	Average Body Weight (g)				Average Tumor Size (T/C)				Toxicity death
			Day 8	14	16	18	Day	14	16	18	
Control	0		30.2	+0.8	+1.7	+2.6	1.00	1.00	1.00	1.00	0/5
dEpo B	30	Q2Dx5	30.3	-2.7	-4.0	-4.5	0.16***	0.15	0.13***		0/3
Taxol®	15	Q2Dx5	30.8	0	-1.1	-1.6	0.81	0.89	0.76		0/4
	24	Q2Dx5	28.5	-4.8	-5.3	-6.0	0.73	0.71*	0.73*		0/4

^a MCF-7/Adr human mammary adenocarcinoma tissue 50 µg was implanted s.c. into mice on day 0. Every other day i.v. infusion were given on a day 8, 10, 12, 14 and 16. The average tumor volume of control group on day 14, 16, and 18 were 1281 ± 145, 1767 ± 161 and 2381 ± 203 mm³ (mean ± SEM), respectively.

^b The i.v. infusion n was for 6 hrs. The vehicle used was in 100 µl (Cremophor + EtOH = 1:1) + 4ml saline.

In further tests, desoxyepothilone B showed similar anticancer efficacy as Taxol® in regular human tumor xenographs in nude mice, represented in Table 21. However, in drug-resistant tumors, desoxyepothilone B is by far better cancer therapeutic agent when compared with Taxol® in all tumors tested. Desoxyepothilone B is not only superior to Taxol® in many respects but is also a better therapeutic agent than epothilone B, camptothecin, vinblastine, adriamycin or VP-16 (etoposide) against many other tumors. See Table 21.

Stability of Desoxyepothilone B in Plasma

As shown in Figure 75, desoxyepothilone B is surprisingly and unexpectedly significantly more stable in human serum plasma than in mouse plasma. Desoxyepothilone B is relatively unstable in mouse plasma with a short half-life of about 15 or 20 min, but is very stable in human plasma with a half-life of about 75 hours. It is therefore likely that desoxyepothilone B can be particularly favorable in treating patients in view of the long lasting effects and the absence of a need to use prolonged i.v. infusions.

Table 20A. Therapeutic effects of desoxyepoB (dEpo B) and Taxol® in nude mice bearing human ovarian UL3-C tumor.^a

Drug	Dose (mg/kg)	Average Body Weight (g)					Average Tumor Size (T/C)			
		Day 19	27	29	31	33	Day 27	29	31	33
Control	0	30.9	+0.9	+0.8	+0.4	+0.1	1.00	1.00	1.00	1.00
dEpo B	30	30.0	-1.5	-4.0	-3.6	-2.7	0.19	0.13	0.03	0.03
Taxol®	20	31.3	-2.9	-3.3	-2.4	-2.7	0.10	0.08	0.03	0.04

^a UL3-C tissue (50 mg) was implanted s.c. into mice on day 0. I.V. infusions were given on day 19, 21, 23, 25 and 27. The average tumor volume of the control group on day 27, 29, 31 and 33 were 349, 378, 488 and 66 mm³, respectively.

Table 21. Comparison Between dEpoB and Taxol® Chemotherapy in Nude Mice

Tumor	Drugs	Doses Schedule	Lowest Average Tumor Size (T/C)	Tumor Disappearance	Therapeutic Effects dEpoB vs Taxol®
A549 Lung	dEpoB Taxol®	40mg/kg Q2D x 3 15mg/kg Q2D x 3	0.01 0.01	1/3 2/4	≡
MX-1	dEpoB Taxol®	30mg/kg Q2D x 6 15mg/kg Q2D x 6	0 0	5/5 5/5	≡
HT-29 Colon	dEpoB Taxol®	30mg/kg Q2D x 6 15mg/kg Q2D x 6	0.02 0.01	0 0	≤
UL3-C Ovary	dEpoB Taxol®	30mg/kg Q2Dx5 15mg/kg Q2Dx5	0.03 0.04	0 0	≥
PC-3 Prostate	dEpoB Taxol®	40mg/kg Q2D x 3 15mg/kg Q2D x 3	0.12 0.02	0 0	< <
SK-OV-3 Ovary	dEpoB Taxol®	30mg/kg Q2D x 6 15mg/kg Q2D x 6	0.17 0.02	0 1/4	< <
MCF-7/Adr Breast	dEpoB Taxol®	30mg/kg Q2D x 5 24mg/kg Q2D x 5	0.11 0.71	0 0	> >
CCRF/Taxol Leukemia	dEpoB Taxol®	30mg/kg Q2D x 6 15mg/kg Q2D x 6	0 1.09	3/3 0	> > > >
CCRF/VBL Leukemia	dEpoB Taxol®	30mg/kg Q2D x 5 15mg/kg Q2D x 5	0 0.76	2/2 0	> > > >
CCRF/CEM Leukemia	dEpoB Taxol®	30mg/kg Q2D x 5 15mg/kg Q2D x 5	0 0	2/2 2/2	≡

Table 22. Comparison of Cancer Chemotherapeutic Effects

Tumor	Route of Administration	Therapeutic effect Rank Order
B16 Melanoma	i.p.	dEpoB>Taxol®>>EpoB
MX-1	i.p.	dEpoB>Camptothecin>Taxol®>VBL, EpoB
MX-1	i.p.	dEpoB>Adriamycin>Taxol®
SK-OV-3	i.v./i.p.	Taxol® ≈ dEpoB
PC-3	i.v./i.p.	Taxol®>dEpoB>>Adriamycin
MCF-7/Adr	i.p.	dEpoB>>Camptothecin>Adriamycin>Taxol®
MX-1	i.v. infusion	Taxol®=dEpoB
MCF-7/Adr	i.v. infusion	dEpoB>>VP-16, Taxol®>VBL, Adriamycin
CCRF-CEM	i.v. infusion	dEpoB ≈ Taxol®
CCRF-CEM/Taxol®	i.v. infusion	dEpoB>>>Taxol®
CCRF-CEM/VBL	i.v. infusion	dEpoB>>>Taxol®
SK-OV-3	i.v. infusion	Taxol®>dEpoB
HT-29	i.v. infusion	Taxol® ≥ dEpoB
A549	i.v. infusion	Taxol®, dEpoB, VBL > VP-16
PC-3	i.v. infusion	Taxol®, VBL ≥ dEpoB >> VP-16

Table 23. Therapeutic Effects of DesoxyepoB and Taxol® in Nude Mice Bearing Human Lymphoblastic Leukemia CCRF-CEM^a.

Drug	Dose	<u>Average Body Weight Changes (g)</u>											
		Day	21	23	25	27	29	31	33	35	37	39	41
Control	0		29.0	+0.1	-1.1	-0.2	+0.8	+0.1	End	End	End	End	End
DesoxyepoB	40		26.6	-1.4	-3.6	-3.9	-5.2	-4.2	-3.1	-2.3	-1.2	-0.2	+0.9
Taxol®	20		29.0	-0.1	-1.9	-2.9	-3.0	-3.6	-2.6	-0.5	+1.2	+1.3	+2.1
<u>Average Tumor Size (T/C)</u>													
<u>Proportion of Tumor Disappearance (n/total)</u>													
Control	0	Day	21	23	25	27	29	31	33	35	37	39	41
			1.00	1.00	1.00	1.00	1.00	End	End	End	End	End	End
			0/5	0/5	0/5	0/5	0/5	0/5					
DesoxyepoB	40		1.10	0.73	0.31	0.09	0	0	0	0	ND ^b	ND	ND
			0/3	0/3	0/3	0/3	3/3	3/3	3/3	3/3	1/3	1/3	0/3
Taxol®	20		1.17	0.78	0.44	0.11	0	0	0	0	ND	ND	ND
			0/4	0/4	0/4	1/4	4/4	4/4	4/4	1/4	0/4	0/4	0/4

^a: CCRF-CEM tissue (50 µg) was implanted s.c. into mice on day 0. I.V. infusion 6hr were given on day 21, 23, 25 and 27. The average tumor volumes of the control group on day 23, 25, 27, 29 and 31 were 376 ± 100, 427 ± 130, 685 ± 144, 850 ± 155, and 1062 ± 165 mm³ (mean ± SEM), respectively.

^b: Tumor reappeared.

"End": Test ended because of tumor burden.

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Table 24. Therapeutic Effects of dEpoB, Taxol®, VBL and VP-16 in Nude Mice Bearing Human Lung Carcinoma A549

Drugs	Dose (mg/kg) Q2D x 3	i.v. infusion (hrs)	Average Body Weight (g)				Average Tumor Size (mm ³)				Tumor Disappearance		
			Day	7	11	13	15	Day	11	13		15	17
Control	0	6		26.4	+1.3	+0.6	+0.2		96	128	306	553	0/4
dEpoB	30	18		29.3	-2.0	-5.8	-5.6		17	21	26	21	1/3
	40	6		27.8	-1.6	-3.2	-2.4		31	19	4	4	1/3
	50	6		27.1	-2.0	-3.2	-2.5		33	19	6	6	1/2
Taxol®	15	6		27.6	-1.2	-0.8	+0.5		49	32	7	6	2/4
	24	6		28.5	-2.1	-2.7	-0.9		14	8	0	0	4/4
VBL	2	i.v. inj		25.5	+13.4	+2.3	+3.2		11	11	11	7	2/3
VP-16	25	i.v. inj		27.2	+0.1	-0.2	-2.2		59	150	275	536	0/3

Table 25. Therapeutic Effects of dEpoB, Taxol®, VBL and VP-16 in Nude Mice Bearing Human Prostate Adenocarcinoma PC-3.

Drugs	Dose (mg/kg)	i.v. infusion (hrs)	Average Body Weight (g)					Average Tumor Size (TC)				Tumor Disappearance
			Day	5	9	11	13	Day	9	11	13	
Control	0	6		26.5	+1.4	+0.5	+0.1		1.00	1.00	1.00	0/5
dEpoB	30	18		29.4	-2.2	-5.9	-5.8		0.17	0.06	0.06	0/3
	40	6		28.3	-1.7	-3.4	-2.7		0.40	0.19	0.12	0/3
	50	6		28.1	-2.1	-3.0	-2.6		0.37	0.13	0.03	0/3
Taxol®	16	6		26.6	-1.1	-0.9	+0.4		0.34	0.09	0.02	0/4
	24	6		28.8	-2.2	-2.8	-0.8		0.18	0.05	0.06	2/4
VBL	2	i.v. inj		23.5	+1.4	+2.1	+3.0		0.37	0.13	0.03	1/3
VP-16	25	i.v. inj		24.9	+0.3	-0.1	-2.4		1.00	1.12	0.88	0/3

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PC-3 tissue (50 µg) was implanted s.c into mice on day 0. I.V. infusions were given on day 5, 7 and 9. The average tumor volumes of control group subjects on 9, 11 and 13 day were 766 ± 50 , 1457 ± 180 and $2441 \pm 221 \text{ mm}^3$ (mean \pm SEM), respectively.

Table 26. Therapeutic Effects of DesoxyepoB and Taxol® in Nude Mice Bearing Human Lymphoblastic Leukemia CCRF-CEM.

Drug	Dose	Average Body Weight Change (g)						Average Tumor Size (T/C)				Tumor Disappearance		
		Day 21		23	25	27	29	31	Day	23	25		27	29
Control	Q2Dx4	0	29.0	+0.1	-1.1	-0.2	+0.8	+0.1	1.00	1.00	1.00	1.00	1.00	0/5
DesoxyepoB	40		26.6	-1.4	-3.6	-3.9	-5.2	-4.2	0.68	0.30	0.09	0	0	3/3
Taxol	20		29.0	-0.1	-1.9	-2.9	-3.0	-3.6	0.78	0.44	0.11	0	0	4/4

CCRF-CEM tissue (50 µg) was implanted s.c into mice on day 0. I.V. infusion 6hr were given on day 21, 23, 25 and 27. The average tumor volume of the control group on day 23, 25, 27, 29 and 31 were 376 ± 100 , 427 ± 130 , 685 ± 144 , 850 ± 155 , and 1062 ± 165 mm³ (mean \pm SEM), respectively.

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Table 27. Comparison of Therapeutic Effects and Toxicity of dEpoB and Paclitaxel with Different Solvents, Routes and Schedules of Administration Using a Non-MDR MX-1 Xenograft^a

Route	Solvent ^b	Dose (mg/kg) ^c	<u>Therapeutic Effect against</u> <u>MX-1 Xenograft^d</u>			<u>Toxicity toward Nude Mice^e</u>	
			dEpoB	Paclitaxel	DepoB	Paclitaxel	Paclitaxel
i.p.	DMSO	35 Q2Dx5	++++	++++	++		++
	Cremophor -EtOH	15 Q2Dx5	+	++	++++		++++
i.v. injection	DMSO	15 Q2Dx5	++	++++	++		++
		24 Q2Dx5	++	++++	++		++
i.v. infusion	Cremophor -EtOH						
	6 hr	30 Q2Dx5	++++	++++	++		++
	24 hr	60 Q4Dx2	++++	ND ^f	+++		ND ^f

a. Approximate relative scale: +, marginal; ++, little; ++++, moderate; +++++, substantial; ++++++, marked.

b. DMSO: dimethylsulfoxide; Cremophor: EtOH (1:1).

c. The dose of dEpoB.

d. Based on tumor volume reduction when compared with the untreated control.

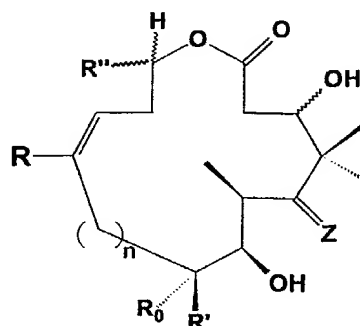
e. Based on body weight decrease or lethality.

f. Not done.

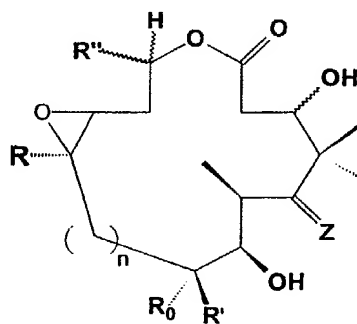
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What is Claimed is:

1. A method of preparing a desoxyepothilone having the structure:



wherein R, R₀, and R' are independently H, linear or branched chain alkyl, optionally substituted by hydroxy, alkoxy, carboxy, carboxaldehyde, linear or branched alkyl or cyclic acetal, fluorine, NR₁R₂, N-hydroximino, or N-alkoxyimino, wherein R₁ and R₂ are independently H, phenyl, benzyl, linear or branched chain alkyl; wherein R'' is -CY=CX-, or H, linear or branched chain alkyl, phenyl, 2-methyl-1,3-thiazolynyl, 2-furanyl, 3-furanyl, 4-furanyl, 2-pyridyl, 3-pyridyl, 4-pyridyl, imidazolyl, 2-methyl-1,3-oxazolynyl, 3-indolyl or 6-indolyl; wherein X is H, linear or branched chain alkyl, phenyl, 2-methyl-1,3-thiazolynyl, 2-furanyl, 3-furanyl, 4-furanyl, 2-pyridyl, 3-pyridyl, 4-pyridyl, imidazolyl, 2-methyl-1,3-oxazolynyl, 3-indolyl or 6-indolyl; wherein Y is H or linear or branched chain alkyl; wherein Z is O, N(OR₃) or N-NR₄R₅, wherein R₃, R₄ and R₅ are independently H or a linear or branched alkyl; and wherein n is 0, 1, 2, or 3; which comprises treating an epothilone having a structure:

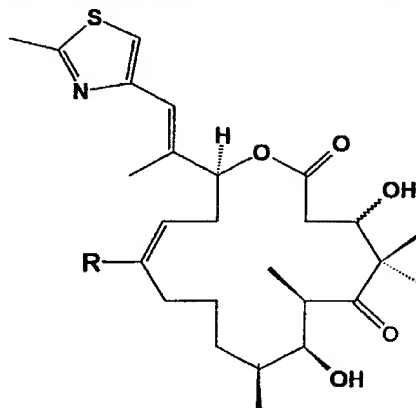


wherein R, R₀, R₁, R₂, R₃, R₄, R₅, R', R'', X, Y, Z and n are defined as for the desoxyepothilone, under suitable conditions so as to deoxygenate the epothilone, and thereby to provide the desoxyepothilone.

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2. The method of claim 1 wherein desoxyepothilone has the structure:

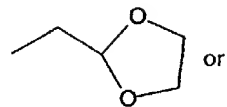
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6

wherein R is H, methyl, ethyl, n-propyl, n-butyl, n-hexyl,

7

(CH₂)₃-OH.



1

2

3. The method of claim 1 wherein the epothilone is deoxygenated using a zinc/copper couple.

1

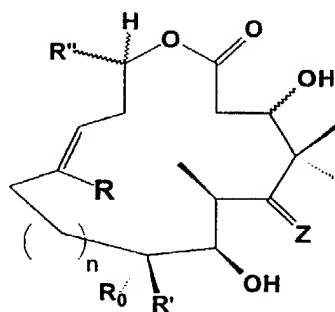
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4. The method of claim 1 wherein the epothilone is deoxygenated in the presence of a polar solvent comprising isopropanol and water.

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2

5. A method of preparing a desoxyepothilone having the structure:



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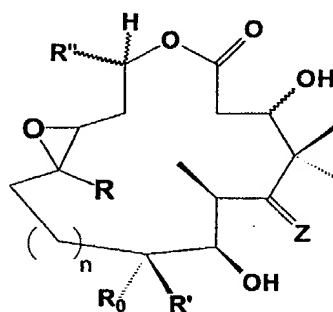
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wherein R, R₀, and R' are independently H, linear or branched chain alkyl, optionally substituted by hydroxy, alkoxy, carboxy, carboxaldehyde, linear or branched alkyl or cyclic acetal, fluorine, NR₁R₂, N-hydroximino, or N-alkoxyimino, wherein R₁ and R₂ are independently H, phenyl, benzyl, linear or branched chain alkyl; wherein R'' is -CY=CHX,

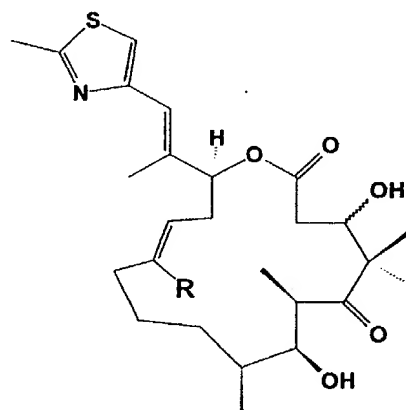
-144-

or H, linear or branched chain alkyl, phenyl, 2-methyl-1,3-thiazoliny, 2-furanyl, 3-furanyl, 4-furanyl, 2-pyridyl, 3-pyridyl, 4-pyridyl, imidazolyl, 2-methyl-1,3-oxazoliny, 3-indolyl or 6-indolyl; wherein X is H, linear or branched chain alkyl, phenyl, 2-methyl-1,3-thiazoliny, 2-furanyl, 3-furanyl, 4-furanyl, 2-pyridyl, 3-pyridyl, 4-pyridyl, imidazolyl, 2-methyl-1,3-oxazoliny, 3-indolyl or 6-indolyl; wherein Y is H or linear or branched chain alkyl; wherein Z is O, N(OR₃) or N-NR₄R₅, wherein R₃, R₄ and R₅ are independently H or a linear or branched chain alkyl; and wherein n is 0, 1, 2, or 3; which comprises treating an epothilone having a structure:



wherein R, R₀, R₁, R₂, R₃, R₄, R₅, R', R'', X, Y, Z and n are defined as for the desoxyepothilone, under suitable conditions so as to deoxygenate the epothilone, and thereby to provide the desoxyepothilone.

6. The method of claim 5 wherein the desoxyepothilone has the structure:



wherein R is H, methyl, ethyl, n-propyl, n-butyl, n-hexyl or hydroxypropyl.

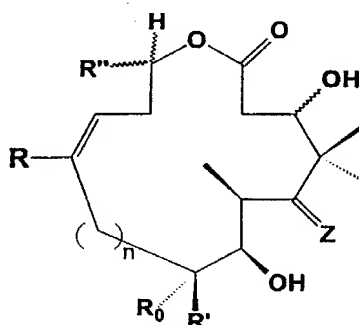
7. The method of claim 5 wherein the epothilone is deoxygenated using a zinc/copper

-145-

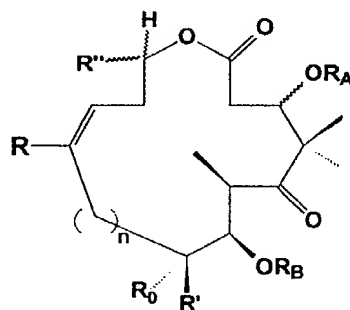
2 couple.

1 8. The method of claim 5 wherein the epothilone is deoxygenated in the presence of a
2 polar solvent comprising isopropanol and water.

1 9. A method of preparing a desoxyepothilone having the structure:
2
3



4 wherein R, R₀, and R' are independently H, linear or branched chain alkyl, optionally
5 substituted by hydroxy, alkoxy, carboxy, carboxaldehyde, linear or branched alkyl or cyclic
6 acetal, fluorine, NR₁R₂, N-hydroximino, or N-alkoxyimino, wherein R₁ and R₂ are
7 independently H, phenyl, benzyl, linear or branched chain alkyl; wherein R'' is -CY=CHX,
8 or H, linear or branched chain alkyl, phenyl, 2-methyl-1,3-thiazolynyl, 2-furanyl, 3-furanyl,
9 4-furanyl, 2-pyridyl, 3-pyridyl, 4-pyridyl, imidazolyl, 2-methyl-1,3-oxazolynyl, 3-indolyl or
10 6-indolyl; wherein X is H, linear or branched chain alkyl, phenyl, 2-methyl-1,3-thiazolynyl,
11 2-furanyl, 3-furanyl, 4-furanyl, 2-pyridyl, 3-pyridyl, 4-pyridyl, imidazolyl, 2-methyl-1,3-
12 oxazolynyl, 3-indolyl or 6-indolyl; wherein Y is H or linear or branched chain alkyl; and
13 wherein Z is O, N(OR₃) or N-NR₄R₅ where R₃, R₄ and R₅ are independently H or a linear or
14 branched alkyl; and wherein n is 0, 1, 2, or 3; which comprises treating a protected
15 desoxyepothilone having the structure:
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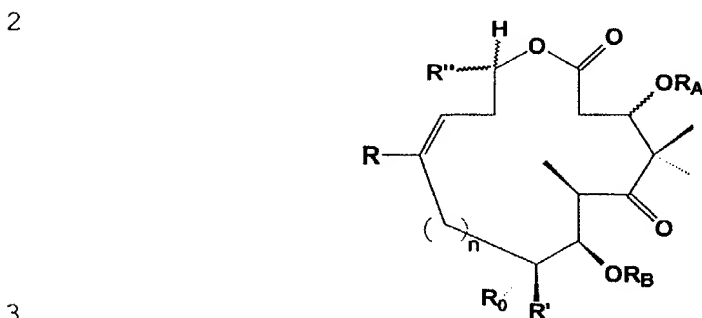
19 wherein R_A is a linear or branched alkyl, alkoxyalkyl, substituted or unsubstituted
 20 aryloxyalkyl, trialkylsilyl, arylalkylsilyl, diarylalkylsilyl, triarylsilyl, linear or branched
 21 acyl, substituted or unsubstituted aroyl or benzoyl; and wherein R_B is hydrogen, t-
 22 butyloxycarbonyl, amyloxycarbonyl, (trialkylsilyl)alkyloxycarbonyl, (dialkylarylsilyl)
 23 alkyloxycarbonyl, benzyl, trialkylsilyl, dialkylarylsilyl, alkylarylsilyl, triarylsilyl, a linear
 24 or branched acyl, substituted or unsubstituted aroyl or benzoyl; under suitable conditions to
 25 form the desoxyepothilone.

26
 27 10. The method of claim 9 wherein n is 3 and R'' is 2-methyl-1,3-thiazolinyl.

1 11. The method of claim 9 wherein R_A is TES and R_B is Troc.

1 12. The method of claim 9 wherein the treating step comprises contacting the protected
 2 desoxyepothilone (i) with SmX_2 , where X is Cl, Br or I, in the presence of a polar
 3 nonaqueous solvent selected from the group consisting of tetrahydrofuran, p-dioxane,
 4 diethyl ether, acetonitrile and N,N-dimethylformamide, and optionally in the
 5 presence of N,N-dimethyl-N'-propylurea or hexamethylphosphoramide and (ii) with
 6 a source of fluoride ion selected from the group consisting of tetra-
 7 methylammonium fluoride, tetra-n-butylammonium fluoride and HF-pyridine.

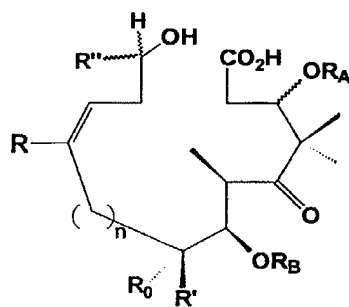
1 13. A method of preparing a protected desoxyepothilone having the structure:



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 4
 5 wherein R , R_0 , and R' are independently H, linear or branched chain alkyl, optionally
 6 substituted by hydroxy, alkoxy, carboxy, carboxaldehyde, linear or branched alkyl or cyclic
 7 acetal, fluorine, NR_1R_2 , N-hydroximino, or N-alkoxyimino, wherein R_1 and R_2 are
 8 independently H, phenyl, benzyl, linear or branched chain alkyl; wherein R'' is $-CY=CHX$,
 9 or H, linear or branched chain alkyl, phenyl, 2-methyl-1,3-thiazolinyl, 2-furanyl, 3-furanyl,
 10 4-furanyl, 2-pyridyl, 3-pyridyl, 4-pyridyl, imidazolyl, 2-methyl-1,3-oxazolinyl, 3-indolyl or

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6-indolyl; wherein X is H, linear or branched chain alkyl, phenyl, 2-methyl-1,3-thiazolinyl, 2-furanyl, 3-furanyl, 4-furanyl, 2-pyridyl, 3-pyridyl, 4-pyridyl, imidazolyl, 2-methyl-1,3-oxazolynyl, 3-indolyl or 6-indolyl; wherein Y is H or linear or branched chain alkyl; wherein n is 2 or 3; wherein R_A is a linear or branched alkyl, alkoxyalkyl, substituted or unsubstituted aryloxyalkyl, trialkylsilyl, arylalkylsilyl, diarylalkylsilyl, triarylsilyl, linear or branched acyl, substituted or unsubstituted aroyl or benzoyl; and wherein R_B is hydrogen, t-butylloxycarbonyl, amyloxycarbonyl, (trialkylsilyl)alkyloxycarbonyl, (dialkylarylsilyl)alkyloxycarbonyl, benzyl, trialkylsilyl, dialkylarylsilyl, alkyldiarylsilyl, triarylsilyl, a linear or branched acyl, substituted or unsubstituted aroyl or benzoyl; which comprises cyclocondensing a hydroxy acid desoxyepothilone precursor having the structure:



wherein R, R_0 , R_A , R_B , R' , R'' and n are defined as above; under suitable conditions to form the protected desoxyepothilone.

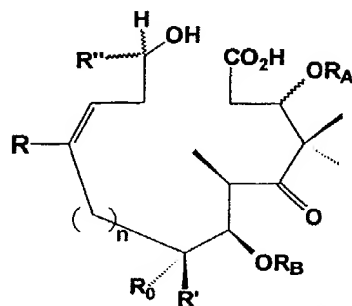
14. The method of claim 13 wherein n is 3 and R'' is 2-methyl-1,3-thiazolinyl.

15. The method of claim 13 wherein R_A is TES and R_B is Troc.

16. The method of claim 13 wherein the hydroxy acid desoxyepothilone precursor is cyclocondensed using a cyclocondensing reagent selected from the group consisting of acetic anhydride, pentafluorophenol, 2,4-dichlorobenzoyl chloride and 2,4,6-trichlorobenzoyl chloride.

17. The method of claim 13 wherein the hydroxyacid is cyclocondensed using 2,4,6-trichlorobenzoyl chloride in the presence of a tertiary amine selected from the group consisting of triethyl amine, tri-n-propylamine, diisopropylethylamine and diethylisopropylamine, and optionally in the presence of pyridine or N,N-dimethylaminopyridine.

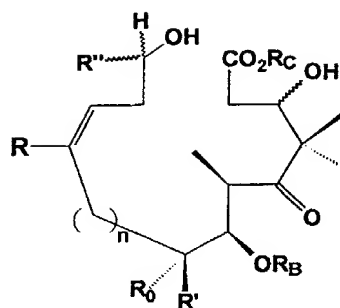
18. A method of preparing a hydroxy acid desoxyepothilone precursor having the structure:



wherein R, R₀, and R' are independently H, linear or branched chain alkyl, optionally substituted by hydroxy, alkoxy, carboxy, carboxaldehyde, linear or branched alkyl or cyclic acetal, fluorine, NR₁R₂, N-hydroximino, or N-alkoxyimino, wherein R₁ and R₂ are independently H, phenyl, benzyl, linear or branched chain alkyl; wherein R'' is -CY=CHX, or H, linear or branched chain alkyl, phenyl, 2-methyl-1,3-thiazolynyl, 2-furanyl, 3-furanyl, 4-furanyl, 2-pyridyl, 3-pyridyl, 4-pyridyl, imidazolyl, 2-methyl-1,3-oxazolynyl, 3-indolyl or 6-indolyl; wherein X is H, linear or branched chain alkyl, phenyl, 2-methyl-1,3-thiazolynyl, 2-furanyl, 3-furanyl, 4-furanyl, 2-pyridyl, 3-pyridyl, 4-pyridyl, imidazolyl, 2-methyl-1,3-oxazolynyl, 3-indolyl or 6-indolyl; wherein Y is H or linear or branched chain alkyl; wherein n is 2 or 3; wherein R_A is a linear or branched alkyl, alkoxyalkyl, substituted or unsubstituted aryloxyalkyl, trialkylsilyl, arylalkylsilyl, diarylalkylsilyl, triarylsilyl, linear or branched acyl, substituted or unsubstituted aroyl or benzoyl; wherein R_B is hydrogen, t-butylloxycarbonyl, amyloxycarbonyl, (trialkylsilyl) alkyloxycarbonyl, (dialkylarylsilyl)alkyloxycarbonyl, benzyl, trialkylsilyl, dialkylarylsilyl, alkyldiarylsilyl, triarylsilyl, linear or branched acyl, substituted or unsubstituted aroyl or benzoyl; which comprises selectively etherifying and hydrolyzing a hydroxy ester desoxyepothilone precursor having the structure:

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wherein R, R₀, R_B, R_C, R', R'' and n are defined as above; and wherein R_C is tertiary-alkyl; under suitable conditions to form the hydroxy acid desoxyepothilone precursor.

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19. The method of claim 18 wherein n is 3 and R'' is 2-methyl-1,3-thiazolinyl.

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20. The method of claim 18 wherein R_A is TES and R_B is Troc.

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21. The method of claim 18 wherein the selective etherifying step comprises contacting the hydroxy ester desoxyepothilone precursor with a silylating reagent to form an ether intermediate, and the hydrolyzing step comprises contacting the ether intermediate with a protic acid or tetra-n-butylammonium fluoride.

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22. The method of claim 21 wherein the silylating reagent is TESOTf in the presence of 2,6-lutidine.

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23. The method of claim 21 wherein the protic acid is HCl in the presence of methyl alcohol.

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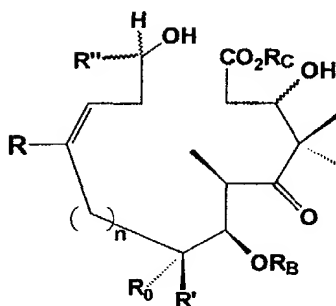
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24. A method of preparing a hydroxy ester desoxyepothilone precursor having the structure:

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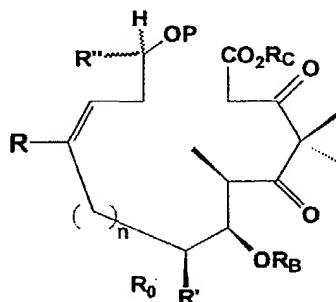
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wherein R, R₀, and R' are independently H, linear or branched chain alkyl, optionally substituted by hydroxy, alkoxy, carboxy, carboxaldehyde, linear or branched alkyl or cyclic acetal, fluorine, NR₁R₂, N-hydroximino, or N-alkoxyimino, wherein R₁ and R₂ are independently H, phenyl, benzyl, linear or branched chain alkyl; wherein R'' is -CY=CHX, or H, linear or branched chain alkyl, phenyl, 2-methyl-1,3-thiazoliny, 2-furanyl, 3-furanyl, 4-furanyl, 2-pyridyl, 3-pyridyl, 4-pyridyl, imidazolyl, 2-methyl-1,3-oxazoliny, 3-indolyl or 6-indolyl; wherein X is H, linear or branched chain alkyl, phenyl, 2-methyl-1,3-thiazoliny, 2-furanyl, 3-furanyl, 4-furanyl, 2-pyridyl, 3-pyridyl, 4-pyridyl, imidazolyl, 2-methyl-1,3-oxazoliny, 3-indolyl or 6-indolyl; wherein Y is H or linear or branched chain alkyl; wherein n is 2 or 3; wherein R_B is hydrogen, t-butyloxycarbonyl, amyloxycarbonyl, (trialkylsilyl)alkyloxycarbonyl, (dialkylarylsilyl)alkyloxycarbonyl, benzyl, trialkylsilyl, dialkylarylsilyl, alkyldiarylsilyl, triarylsilyl, linear or branched acyl, substituted or unsubstituted aroyl or benzoyl; and wherein R_c is tertiary-alkyl; which comprises reducing a hydroxy ketoester desoxyepothilone precursor having the structure:



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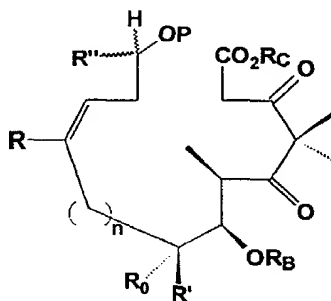
26

wherein P, R, R₀, R_B, R_c, R', R'' and n are defined as above; under suitable conditions to form the hydroxy ester desoxyepothilone precursor.

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25. The method of claim 24 wherein n is 3 and R'' is 2-methyl-1,3-thiazoliny.

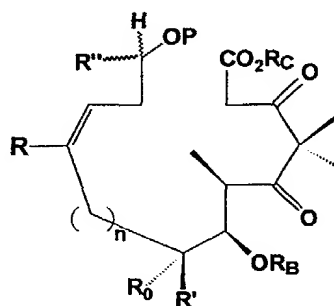
- 1 26. The method of claim 24 wherein R_A is TES and R_B is Troc.
- 1 27. The method of claim 24 wherein the reducing step comprises contacting the hydroxy
2 ketoester desoxyepothilone precursor with a stereospecific reducing reagent.
- 1 28. The method of claim 24 wherein the stereospecific reducing reagent comprises
2 hydrogen gas at from about 900 pounds per square inch to about 2200 pounds per
3 square inch in the presence of (R)-(BINAP)RuCl₂ and optionally in the presence of HCl
4 and an alcohol selected from the group consisting of MeOH, EtOH, and i-PrOH.
- 1 29. A method of preparing a hydroxy ketoester desoxyepothilone precursor having the
2 structure:



- 4 wherein P is H; wherein R, R_B , and R' are independently H, linear or branched chain alkyl,
5 optionally substituted by hydroxy, alkoxy, carboxy, carboxaldehyde, linear or branched alkyl
6 or cyclic acetal, fluorine, NR₁R₂, N-hydroximino, or N-alkoxyimino, wherein R₁ and R₂ are
7 independently H, phenyl, benzyl, linear or branched chain alkyl; wherein R'' is -CY=CHX,
8 or H, linear or branched chain alkyl, phenyl, 2-methyl-1,3-thiazolynyl, 2-furanyl, 3-furanyl,
9 4-furanyl, 2-pyridyl, 3-pyridyl, 4-pyridyl, imidazolyl, 2-methyl-1,3-oxazolynyl, 3-indolyl or
10 6-indolyl; wherein X is H, linear or branched chain alkyl, phenyl, 2-methyl-1,3-thiazolynyl,
11 2-furanyl, 3-furanyl, 4-furanyl, 2-pyridyl, 3-pyridyl, 4-pyridyl, imidazolyl, 2-methyl-1,3-
12 oxazolynyl, 3-indolyl or 6-indolyl; wherein Y is H or linear or branched chain alkyl; wherein
13 n is 2 or 3; wherein R_B is hydrogen, t-butyloxycarbonyl, amyloxycarbonyl,
14 (trialkylsilyl)alkyloxycarbonyl, (dialkylarylsilyl) alkyloxycarbonyl, benzyl, trialkylsilyl,
15 dialkylarylsilyl, alkylarylsilyl, triarylsilyl, a linear or branched acyl, substituted or
16 unsubstituted aroyl or benzoyl; and wherein R_C is tertiary-alkyl; which comprises
17 deprotecting a protected ketoester desoxyepothilone precursor having the structure:
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wherein R, R₀, R_A, R_B, R_C, R', R'' and n are defined as above; and wherein P is a linear or branched alkyl, alkoxyalkyl, substituted or unsubstituted aryloxyalkyl, trialkylsilyl, aryldialkylsilyl, diarylalkylsilyl or triarylsilyl; under suitable conditions to form the hydroxy ketoester desoxyepothilone precursor.

1

30. The method of claim 29 wherein n is 3 and R'' is 2-methyl-1,3-thiazolinyl.

1

31. The method of claim 29 wherein R_A is TES and R_B is Troc.

1

32. The method of claim 29 wherein P is TBS.

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33. The method of claim 29 wherein the deprotecting step comprises contacting the protected ketoester desoxyepothilone precursor with a protic acid.

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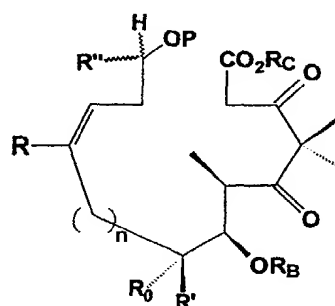
34. The method of claim 33 wherein the protic acid is HCl in methyl alcohol or ethyl alcohol.

1

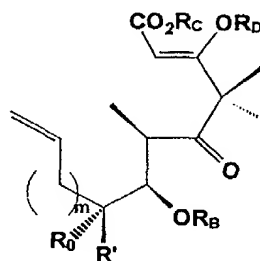
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35. A method of preparing a protected ketoester desoxyepothilone precursor having the structure:

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wherein P is a linear or branched alkyl, alkoxyalkyl, substituted or unsubstituted aryloxyalkyl, trialkylsilyl, arylalkylsilyl, diarylalkylsilyl or triarylsilyl; wherein R, R₀, and R' are independently H, linear or branched chain alkyl, optionally substituted by hydroxy, alkoxy, carboxy, carboxaldehyde, linear or branched alkyl or cyclic acetal, fluorine, NR₁R₂, N-hydroximino, or N-alkoxyimino, wherein R₁ and R₂ are independently H, phenyl, benzyl, linear or branched chain alkyl; wherein R'' is -CY=CHX, or H, linear or branched chain alkyl, phenyl, 2-methyl-1,3-thiazolinyl, 2-furanyl, 3-furanyl, 4-furanyl, 2-pyridyl, 3-pyridyl, 4-pyridyl, imidazolyl, 2-methyl-1,3-oxazolinyl, 3-indolyl or 6-indolyl; wherein X is H, linear or branched chain alkyl, phenyl, 2-methyl-1,3-thiazolinyl, 2-furanyl, 3-furanyl, 4-furanyl, 2-pyridyl, 3-pyridyl, 4-pyridyl, imidazolyl, 2-methyl-1,3-oxazolinyl, 3-indolyl or 6-indolyl; wherein Y is H or linear or branched chain alkyl; wherein n is 2 or 3; wherein R_B is hydrogen, t-butyloxycarbonyl, amyloxycarbonyl, (trialkylsilyl)alkyl-oxycarbonyl, (dialkylarylsilyl)alkyloxycarbonyl, benzyl, trialkylsilyl, dialkylarylsilyl, alkyldiarylsilyl, triarylsilyl, a linear or branched acyl, substituted or unsubstituted aroyl or benzoyl; and wherein R_C is tertiary-alkyl; which comprises coupling a terminal vinyl enol ether ester having the structure:

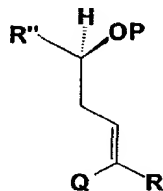


wherein R, R₀, R_B, R_C, and R' are defined as above; wherein m is 0, 1 or 2; and wherein R_D is linear or branched alkyl, benzyl, trialkylsilyl, dialkylarylsilyl, alkyldiarylsilyl, linear or branched acyl, substituted or unsubstituted aroyl or benzoyl; with a protected halovinyl or

-154-

29 metalvinyl compound having the structure:

30



31

32 wherein R, P and R'' are defined as above; and wherein Q is a halide or a metal; under
33 suitable conditions to form the protected ketoester desoxyepothilone precursor.

1 36. The method of claim 35 wherein n is 3 and R'' is 2-methyl-1,3-thiazolinyl.

1 37. The method of claim 35 wherein R_A is TES and R_B is Troc.

1 38. The method of claim 35 wherein P is TBS or TES.

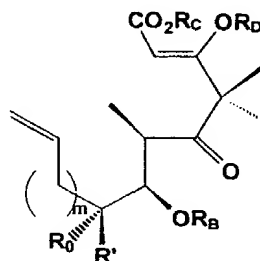
1 39. The method of claim 35 wherein Q is iodine or bromine.

1 40. The method of claim 35 wherein R_D is methyl or TES.

1 41. The method of claim 35 wherein the coupling step comprises contacting the terminal
2 vinyl enol ether ester and the protected halovinyl compound with noble metal
3 complex capable of effecting a Suzuki coupling.

1 42. The method of claim 35 wherein the noble metal complex is Pd(dppf)₂Cl₂ in the
2 presence of Ph₃As and Cs₂CO₃.

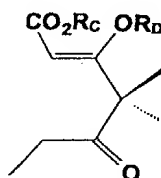
1 43. A method of preparing a terminal vinyl enol ether ester having the structure:



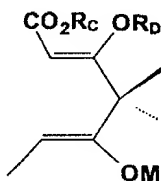
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wherein R_0 and R' are independently H, linear or branched chain alkyl, optionally substituted by hydroxy, alkoxy, carboxy, carboxaldehyde, linear or branched alkyl or cyclic acetal, fluorine, NR_1R_2 , N-hydroximino, or N-alkoxyimino, wherein R_1 and R_2 are independently H, phenyl, benzyl, linear or branched chain alkyl; wherein m is 0, 1 or 2; wherein R_8 is hydrogen, t-butyloxycarbonyl, amyloxycarbonyl, (trialkylsilyl)alkyl-oxycarbonyl, (dialkylarylsilyl)alkyl-oxycarbonyl, benzyl, trialkylsilyl, dialkylarylsilyl, alkyl-diarylsilyl, triarylsilyl, linear or branched acyl, substituted or unsubstituted aroyl or benzoyl; wherein R_C is tertiary-alkyl; and wherein R_D is linear or branched alkyl, benzyl, trialkylsilyl, dialkylarylsilyl, alkyl-diarylsilyl, triarylsilyl, linear or branched acyl, substituted or unsubstituted aroyl or benzoyl; which comprises:

(a) treating a keto enol ester having the structure:

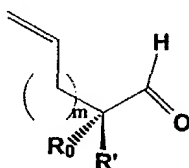


under suitable conditions to form an enolate enol ester having the structure:



wherein M is Li, Na or K; and

(b) coupling the enolate enol ester with a vinyl aldehyde having the structure:



wherein m , and R_0 and R' are as defined above; under suitable conditions to form the terminal vinyl enol ether ester.

44. The method of claim 43 wherein the treating step comprises contacting the keto enol ester with a strong nonnucleophilic base selected from the group consisting of lithium diethylamide, lithium diisopropylamide, lithium hydride,

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- 4 sodium hydride, potassium hydride and potassium t-butoxide.
5
6 45. The method of claim 44 wherein the treating step is effected in a polar nonaqueous
7 solvent selected from the group consisting of tetrahydrofuran, diethyl ether, di-n-
8 propyl ether and dimethylformamide at a temperature from about -100°C to about
9 +10°C.
10
11 46. The method of claim 44 wherein the temperature is from about -20°C to -40°C.
12
13 47. The method of claim 43 wherein the coupling step comprises contacting the enolate
14 enol ester with the vinyl aldehyde at a temperature from about -130°C to about -
15 78°C.

FIG. 1A

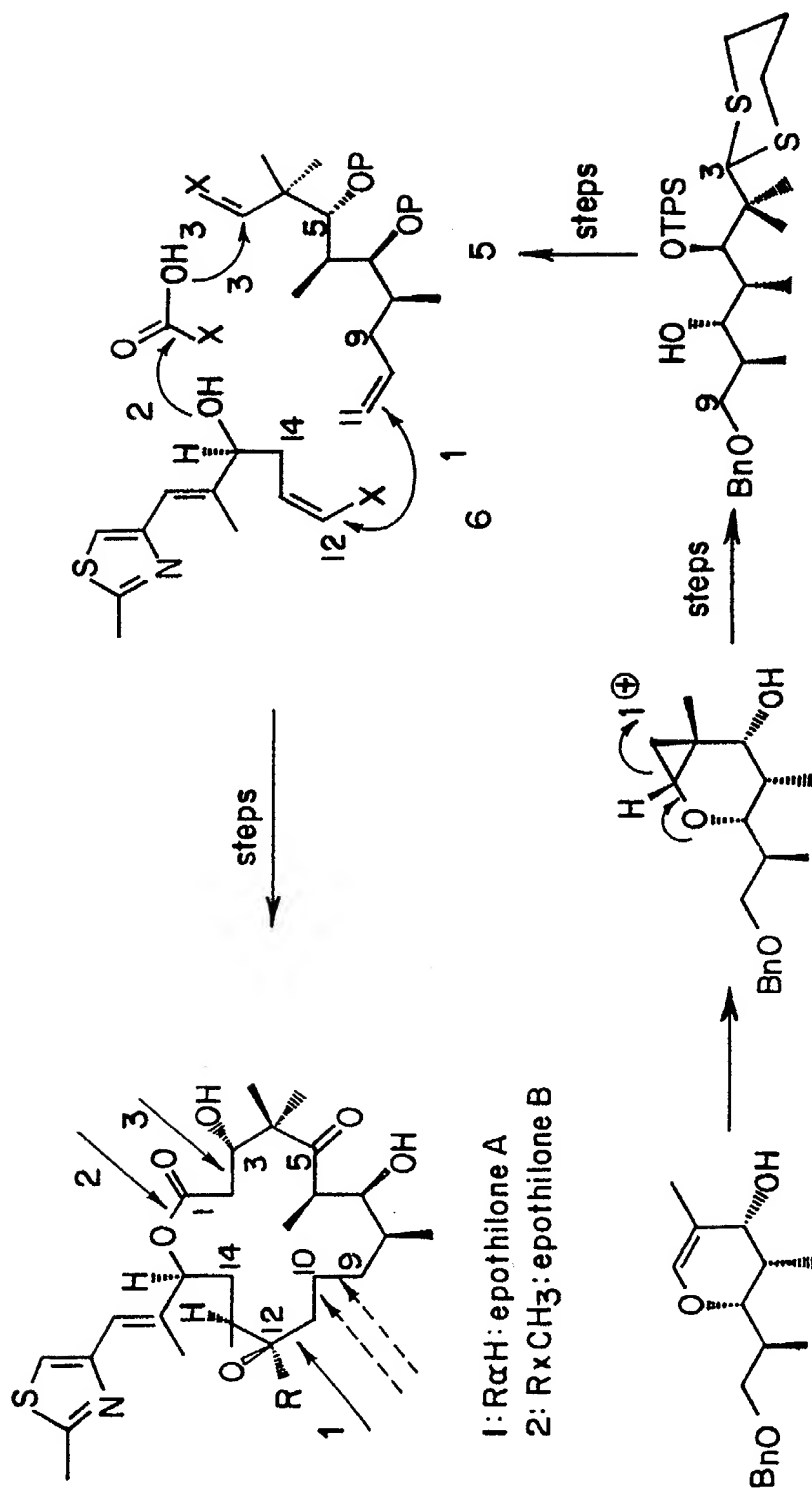


FIG. 1B

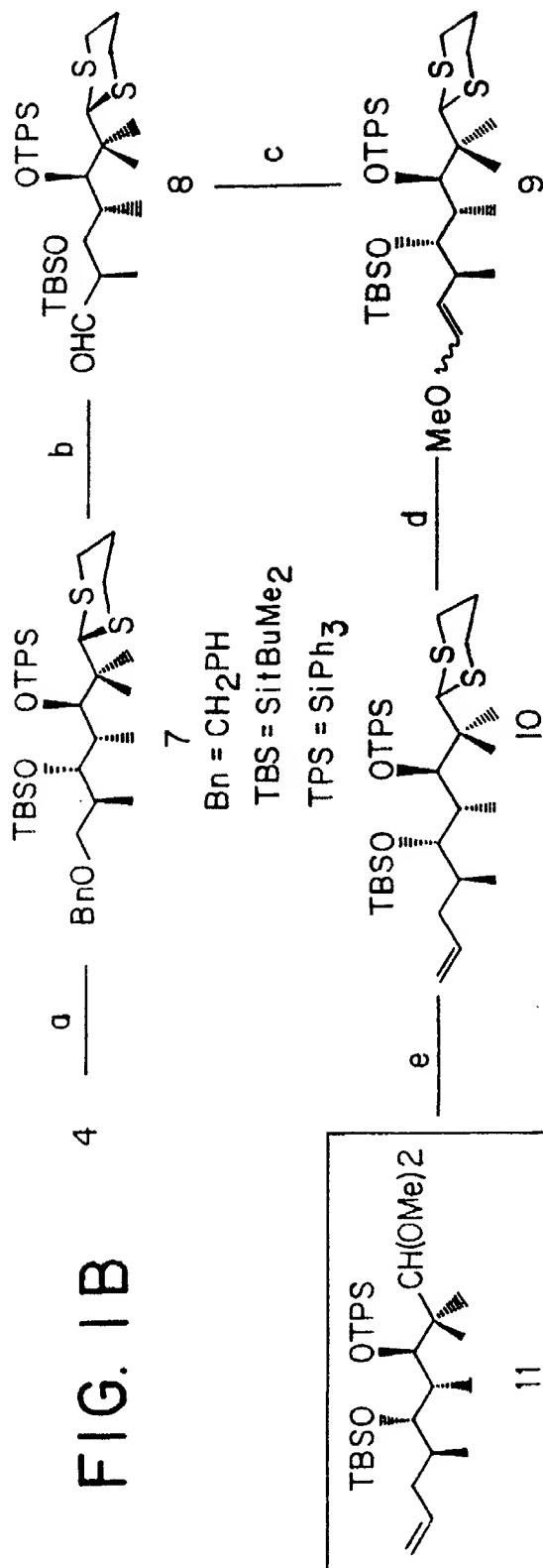
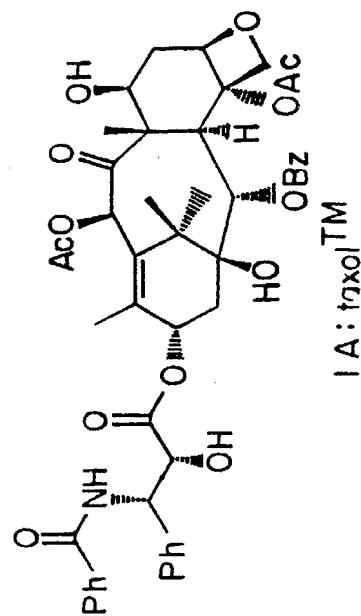


FIG. 12B



1A: traxol™

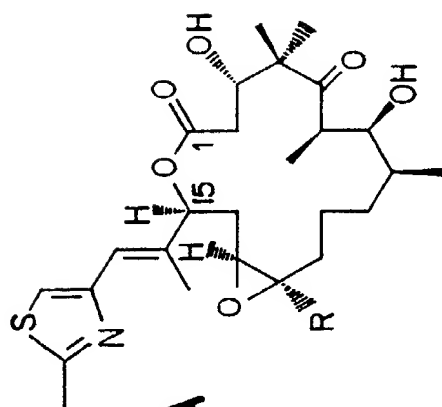
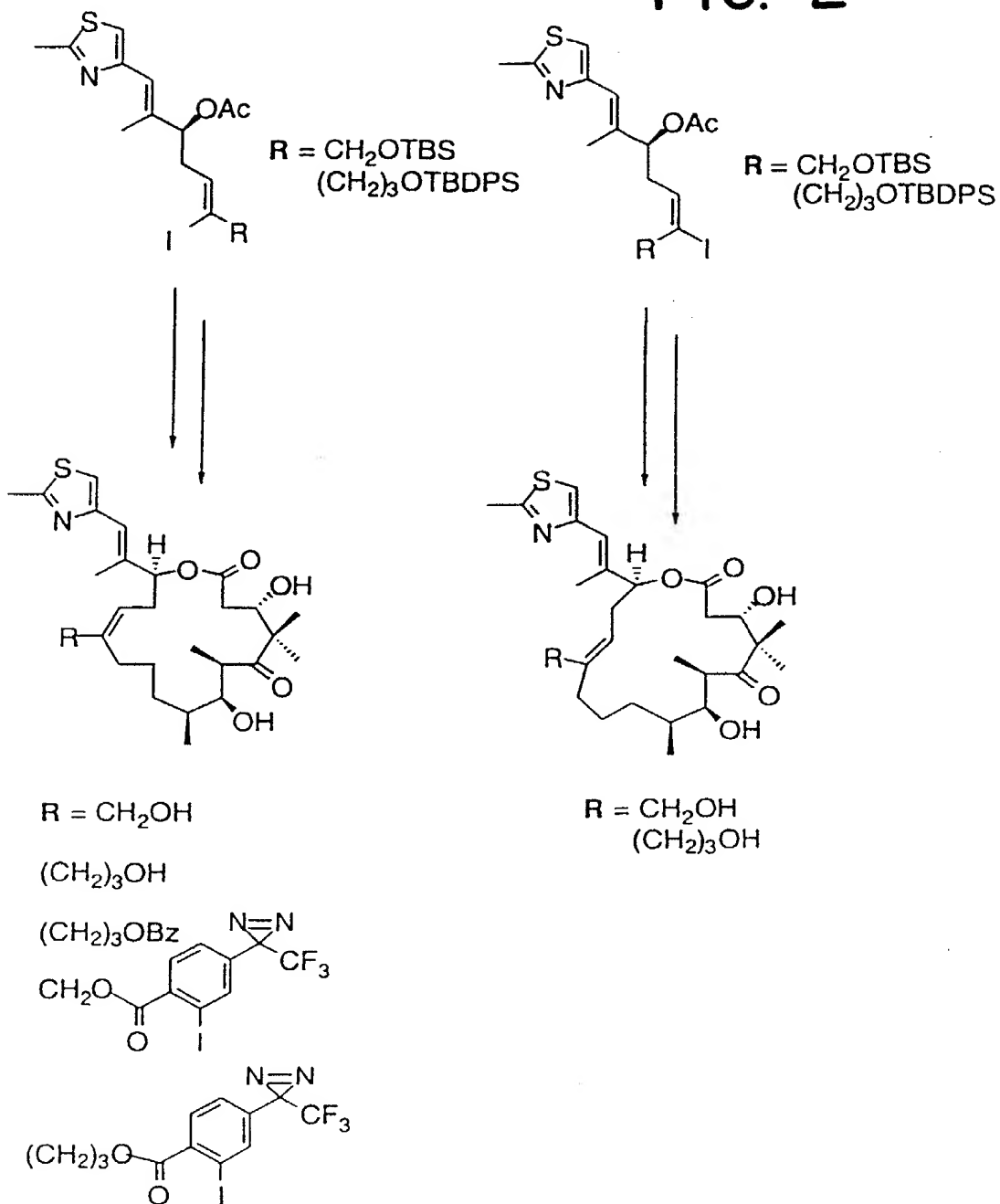


FIG. 12A

R = H: epothilone A
 R = CH₃: epothilone B

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FIG. 2



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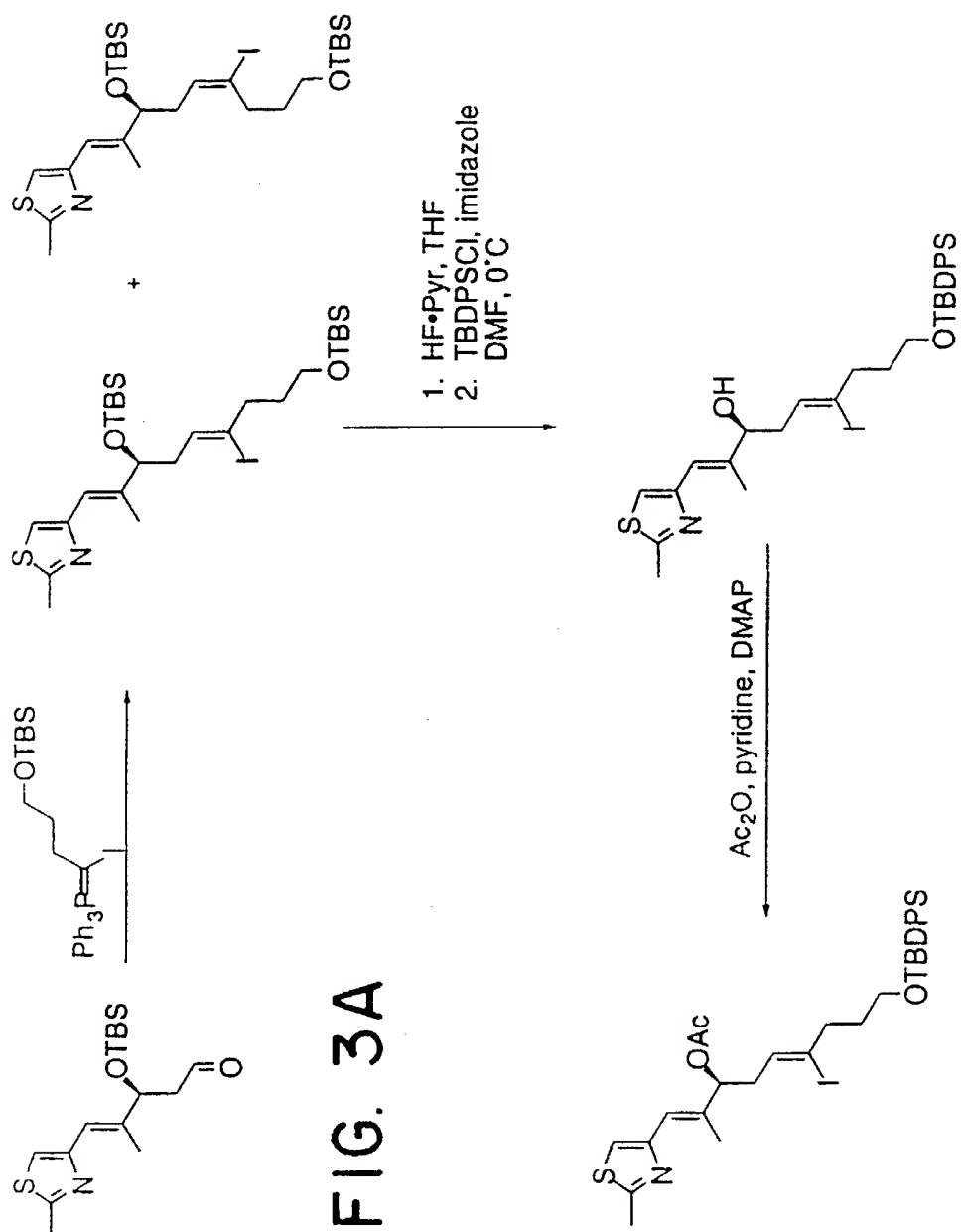
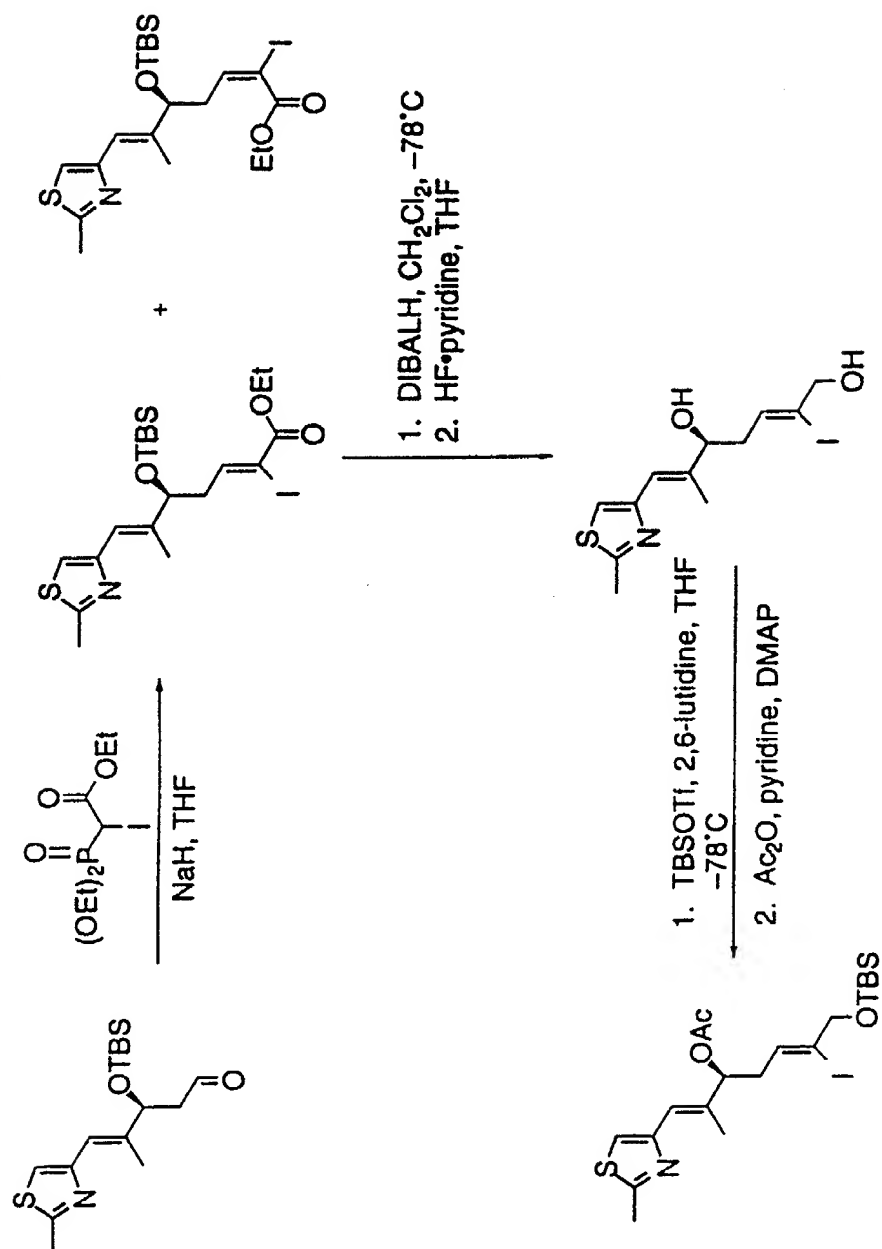


FIG. 3A

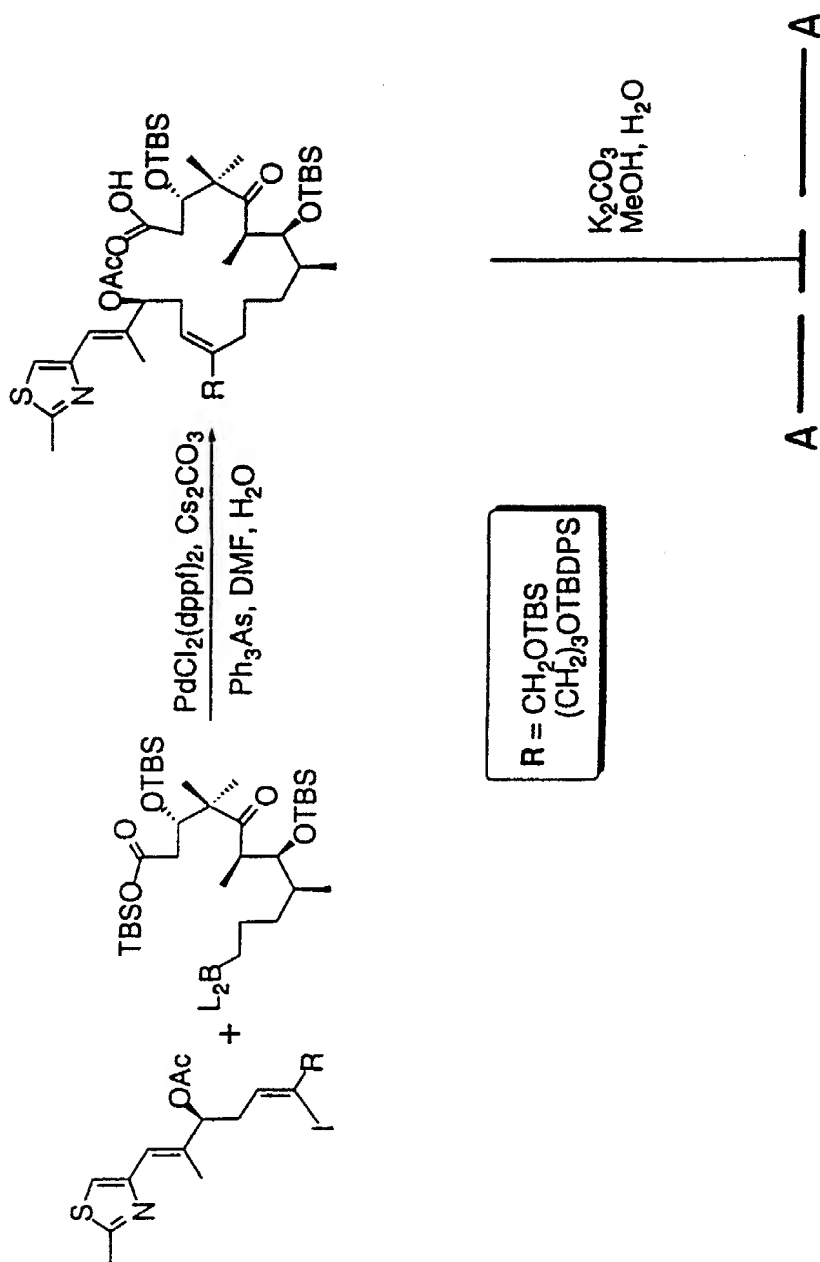
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FIG. 3B

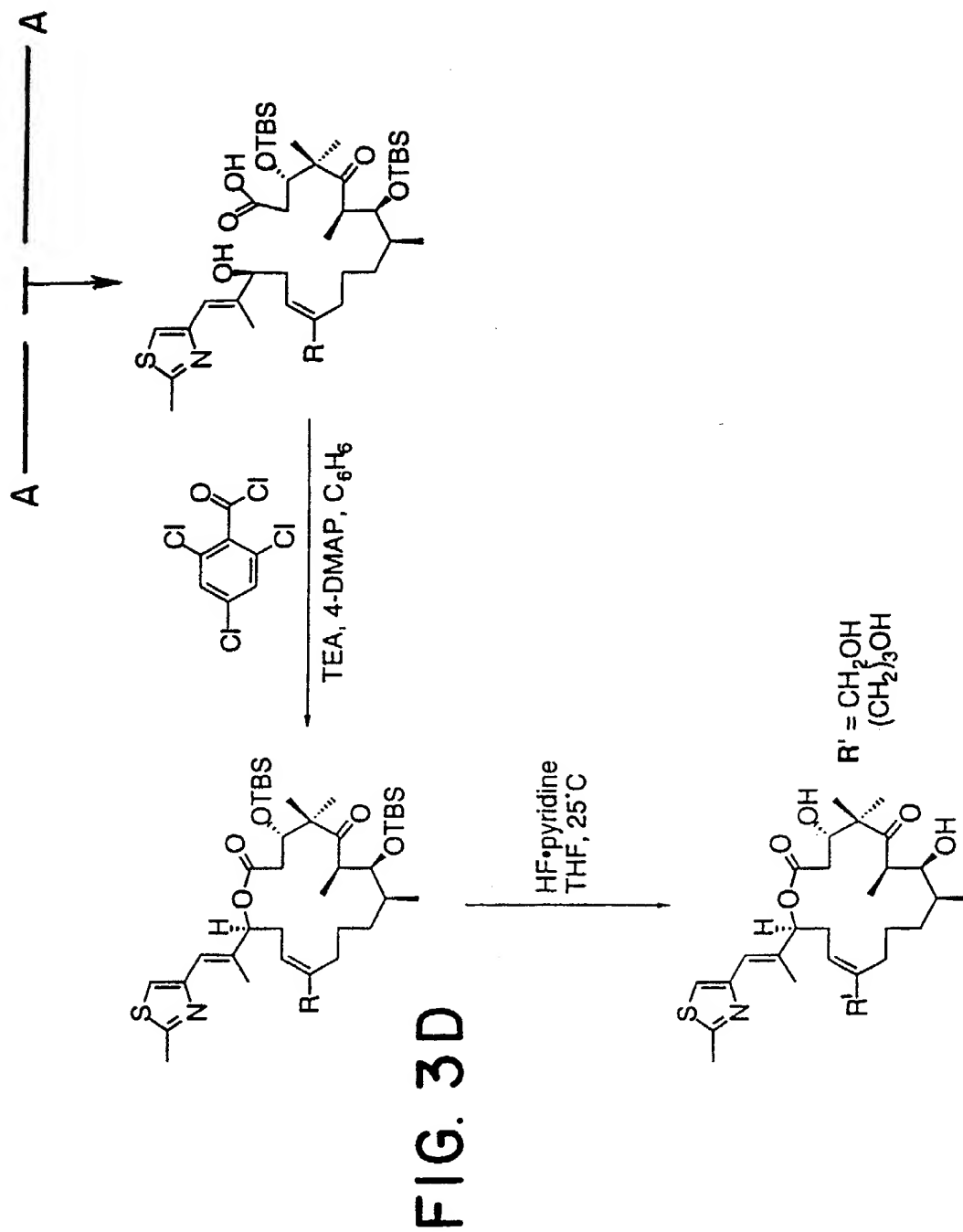


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FIG. 3C



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FIG. 3E

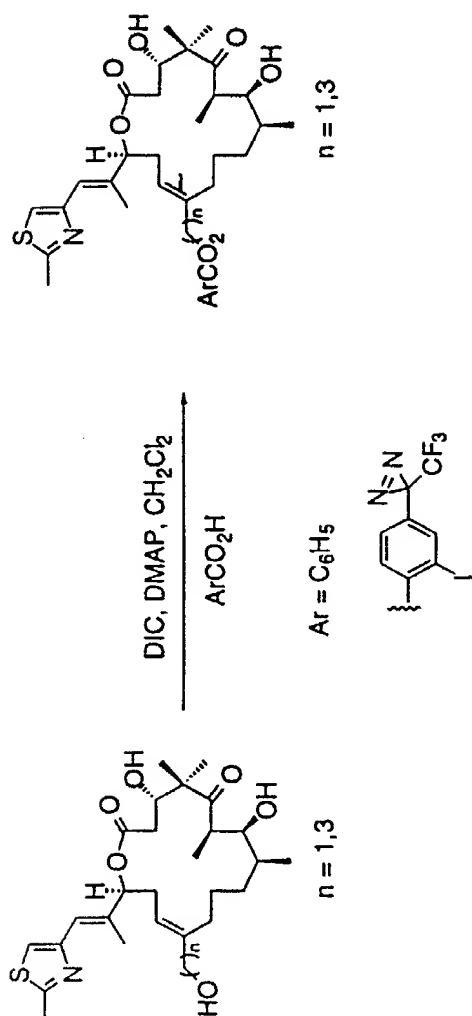
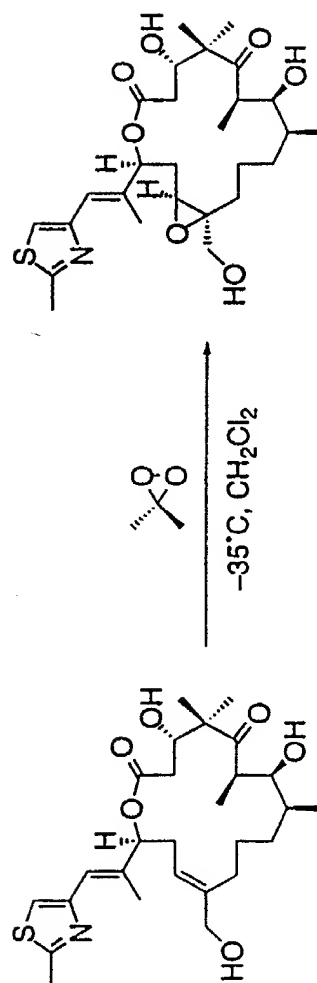


FIG. 3F



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FIG. 4A

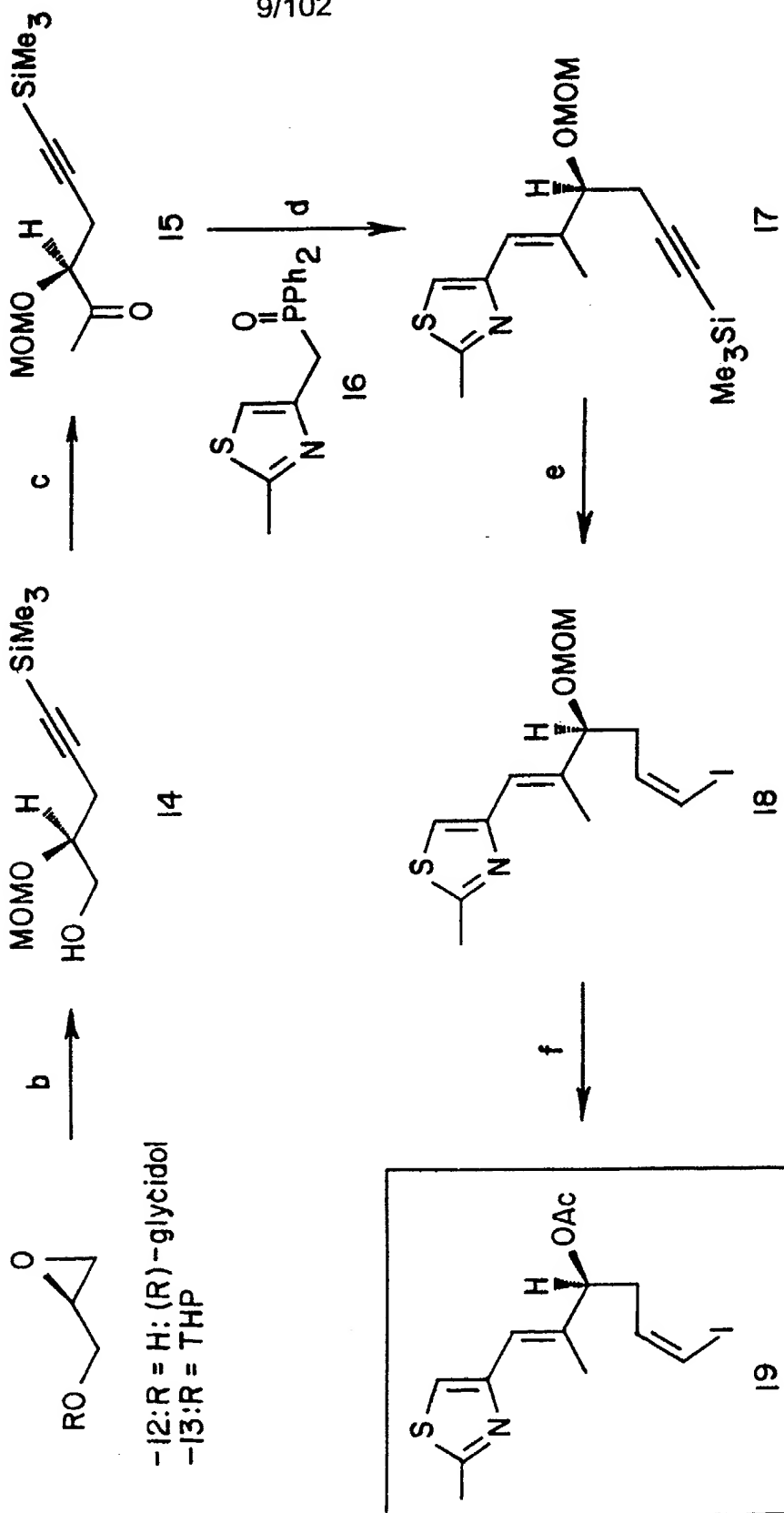


FIG. 4B

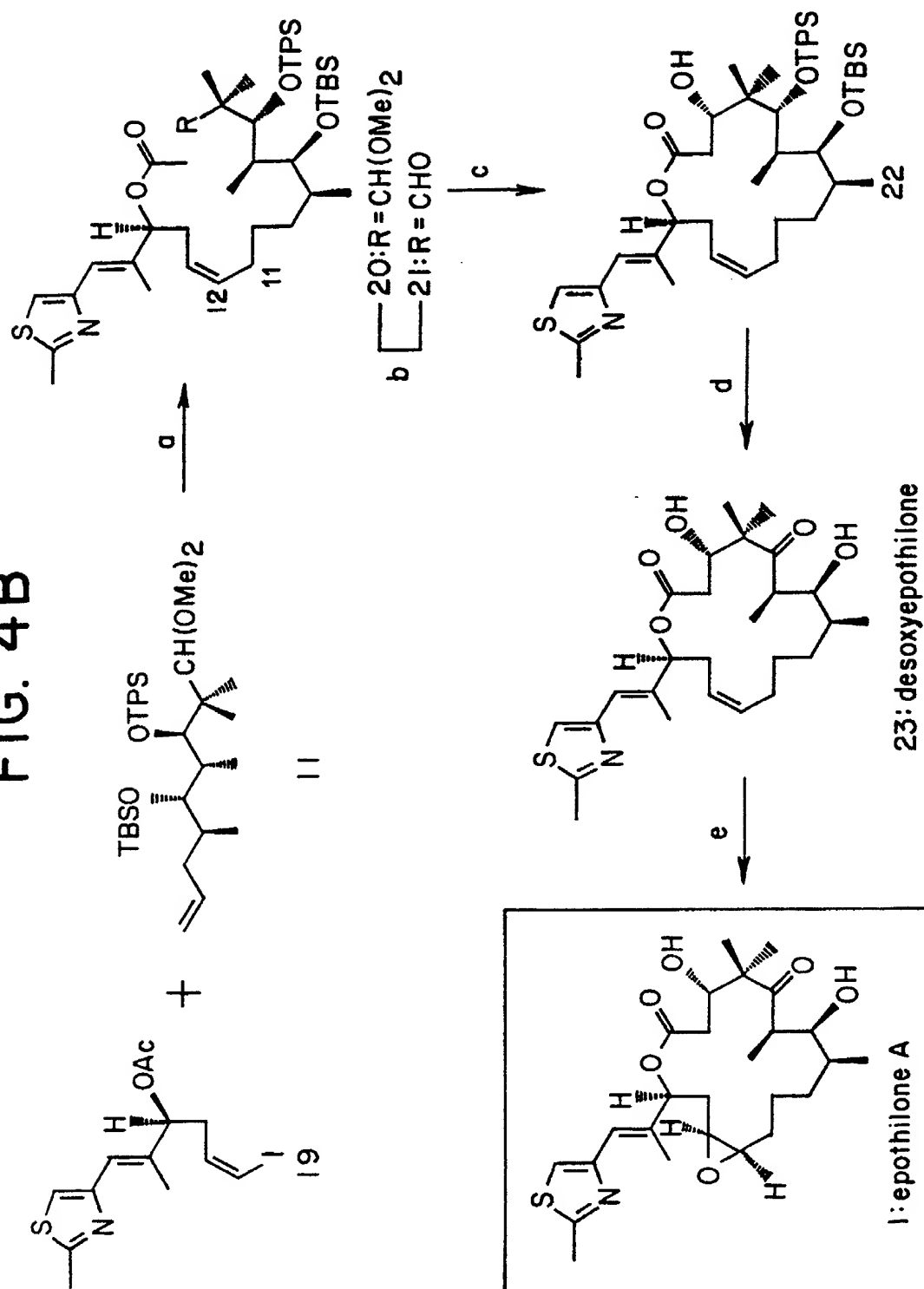
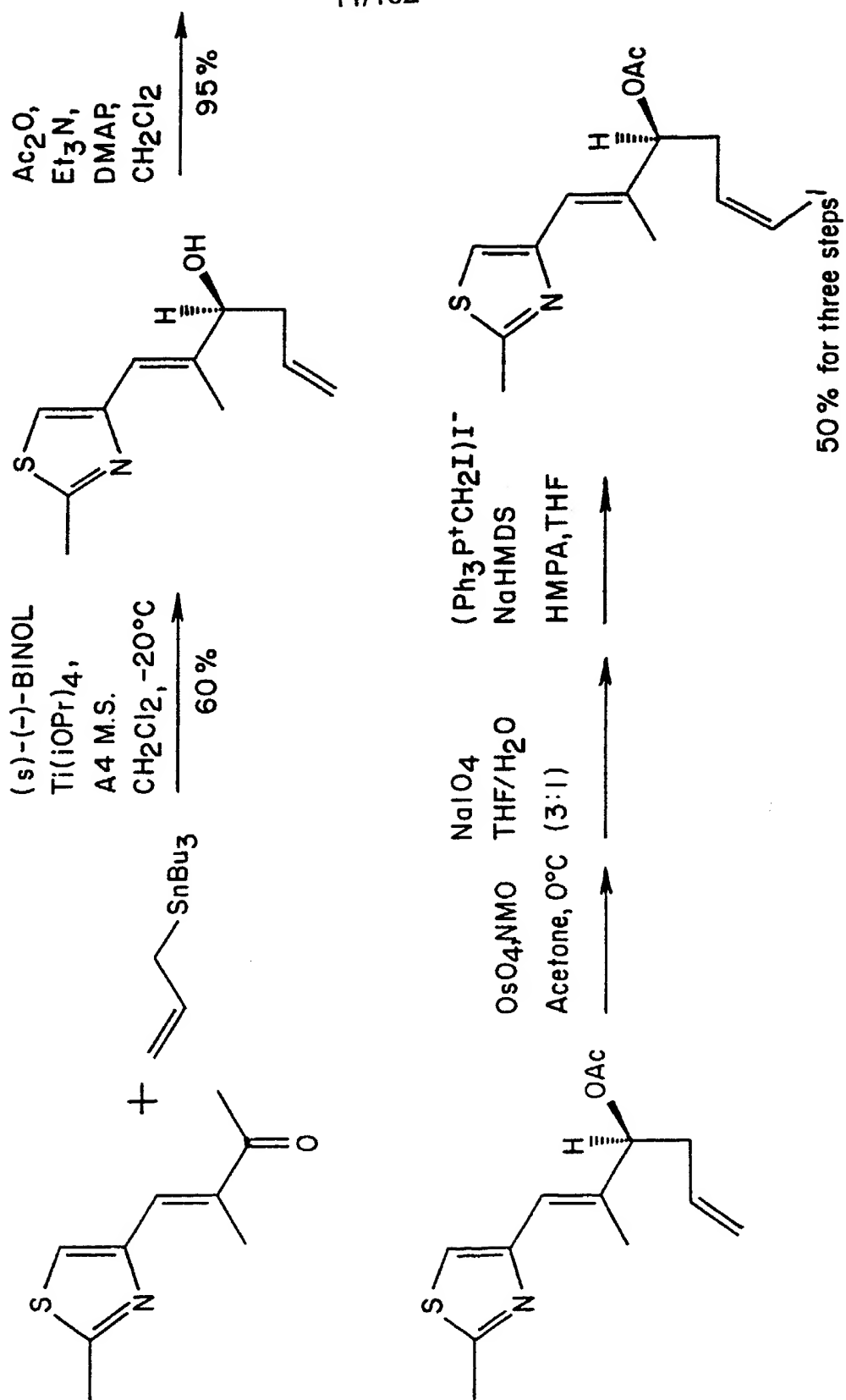
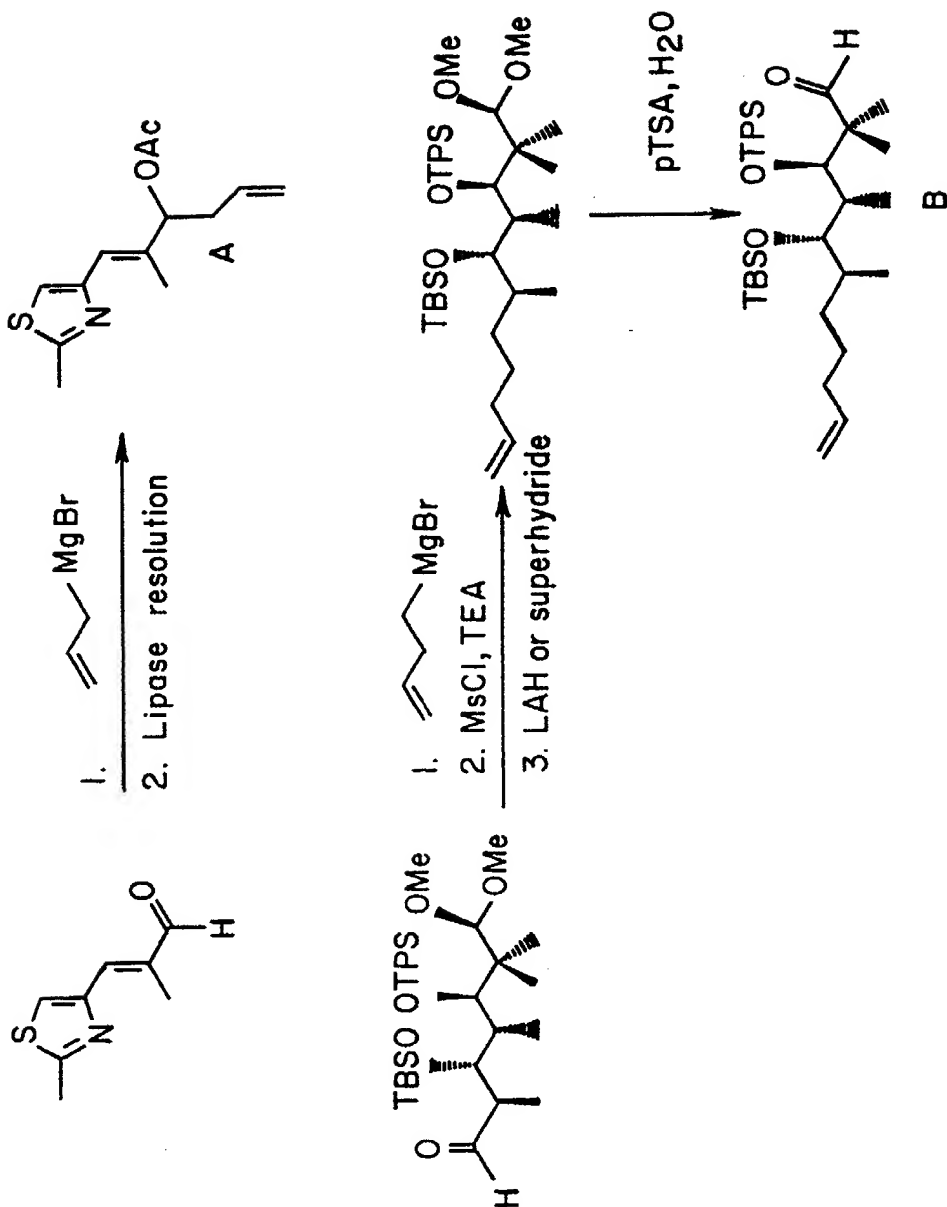


FIG. 5



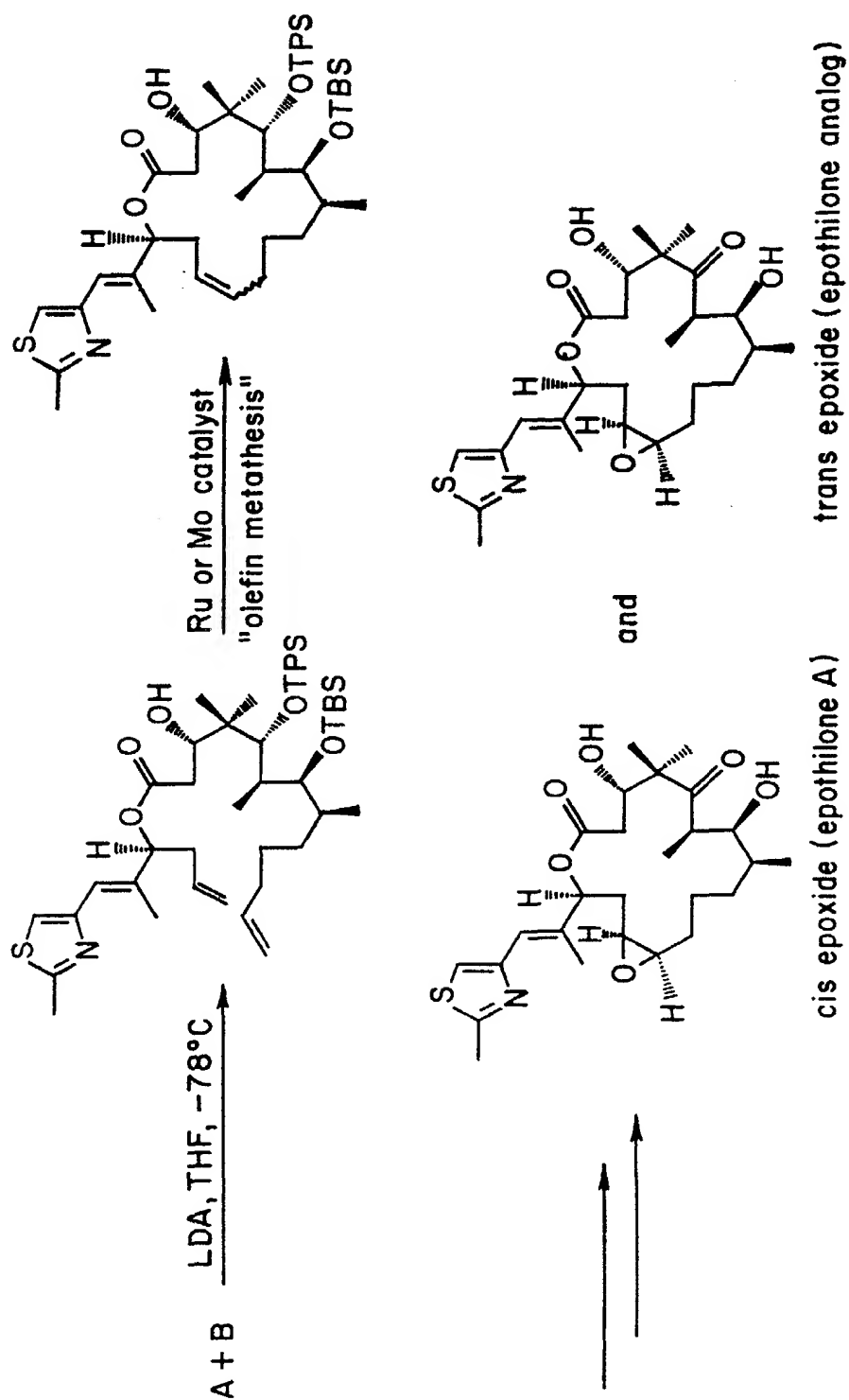
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FIG. 6A



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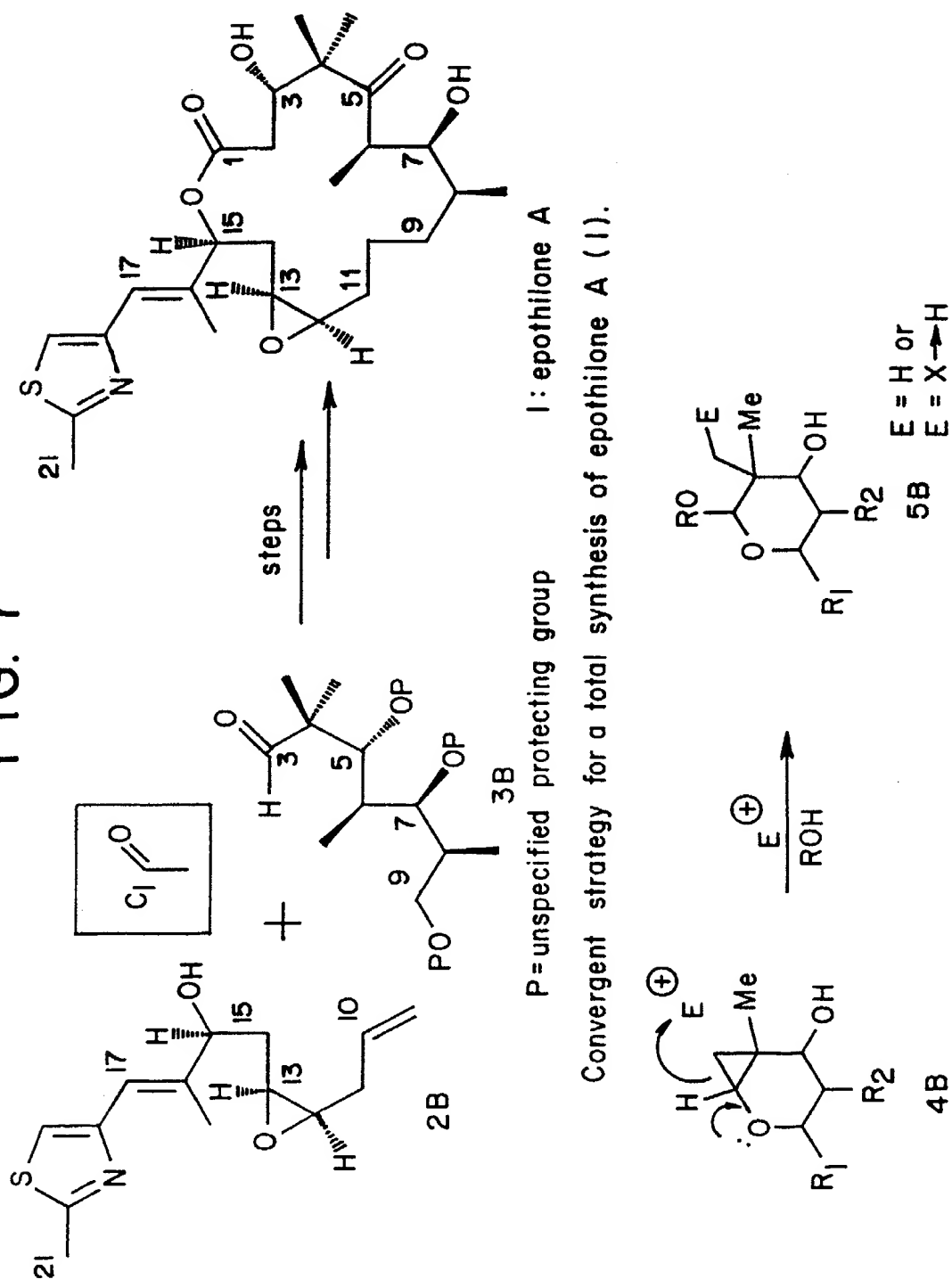
FIG. 6B

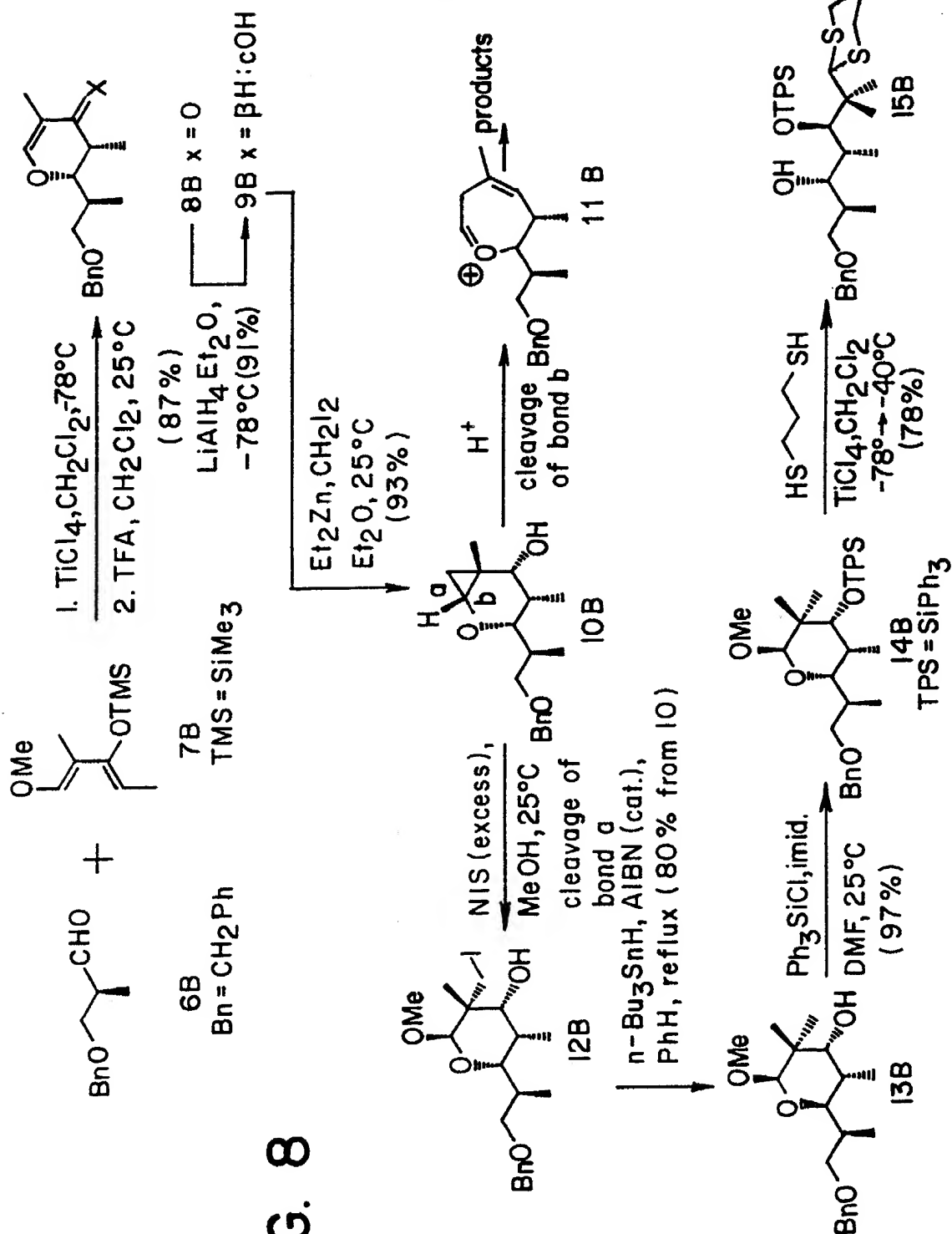


*17 steps from known starting materials vs. 27 steps for aldol macrocyclization

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FIG. 7

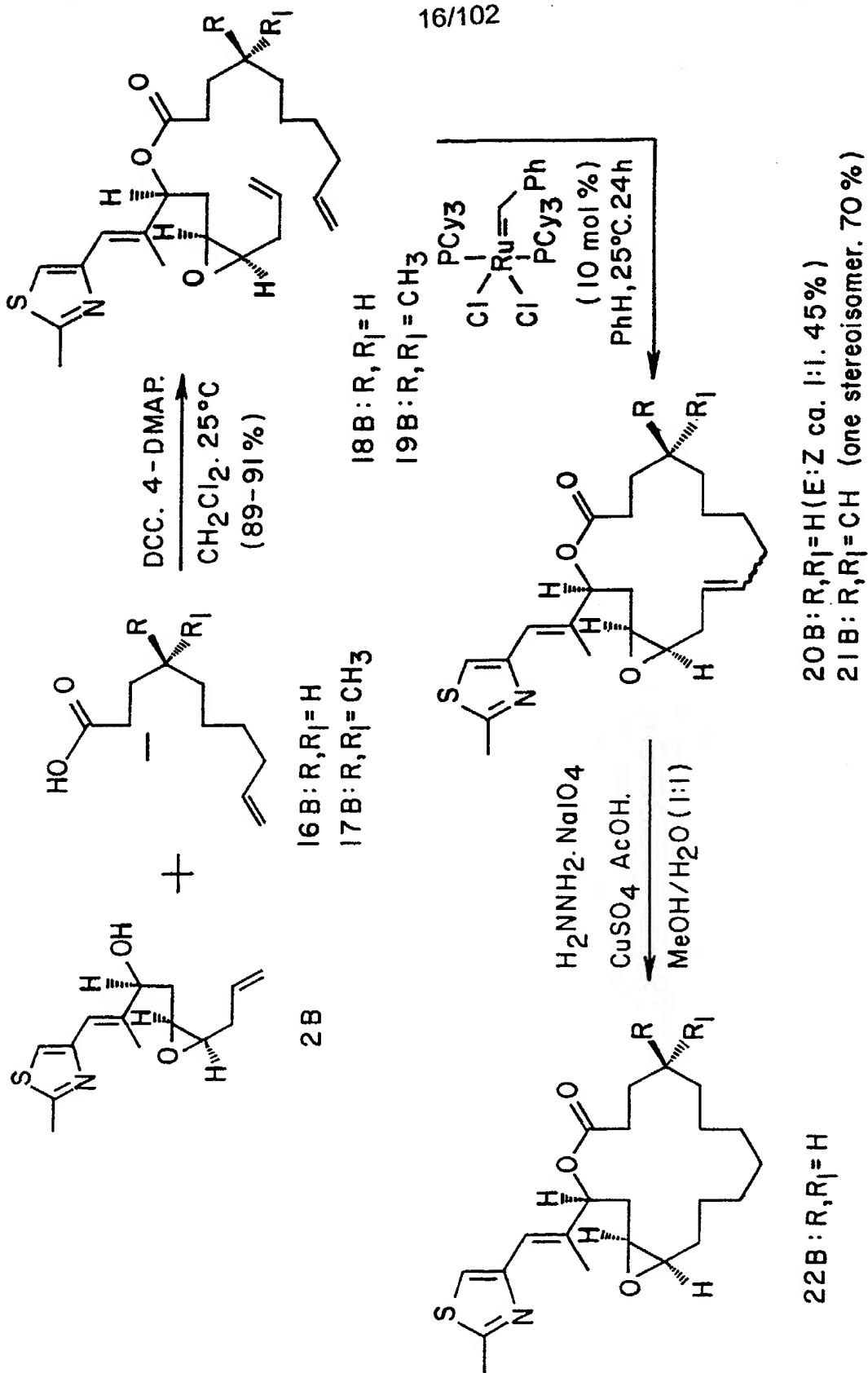




ॐ
ॐ
ॐ

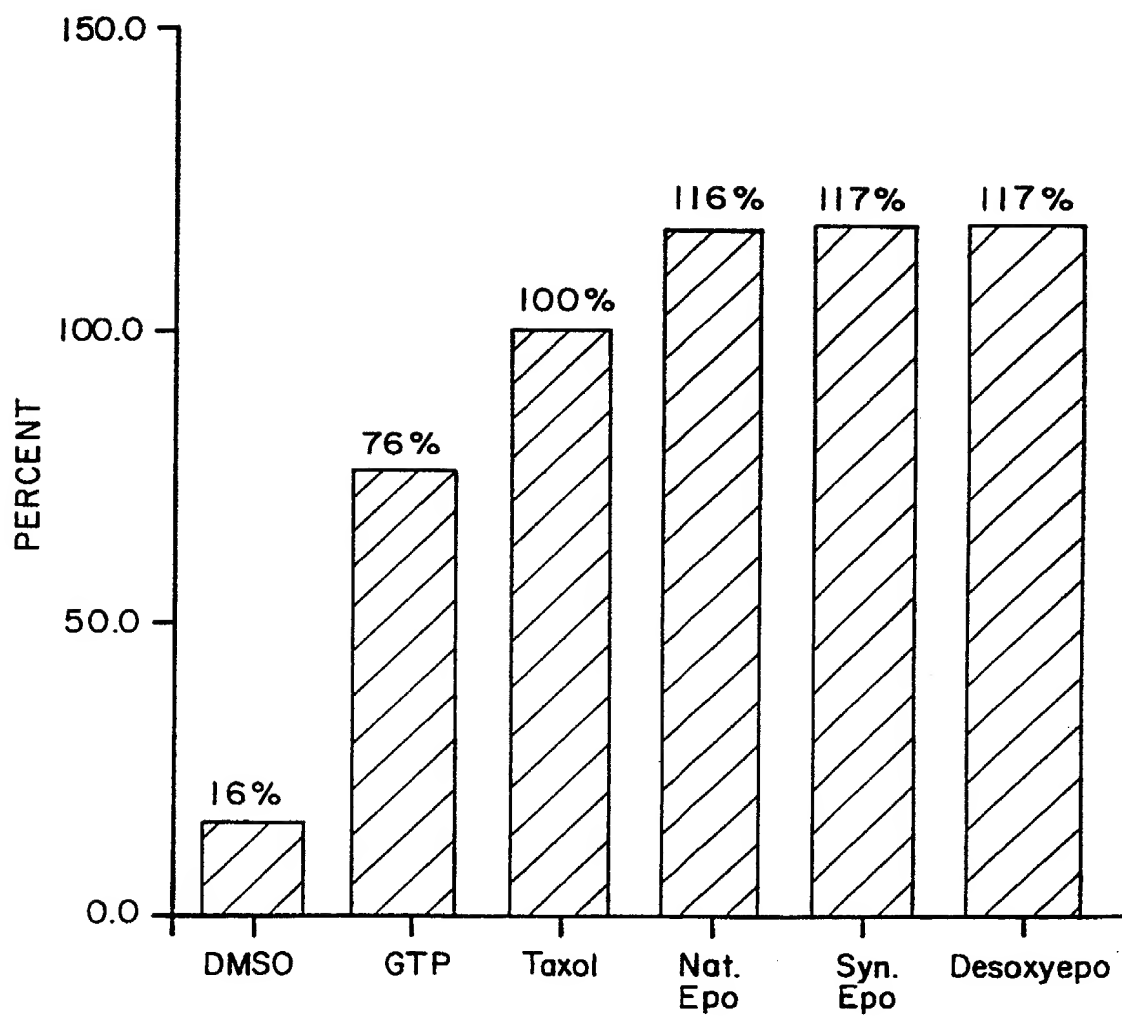
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FIG. 9



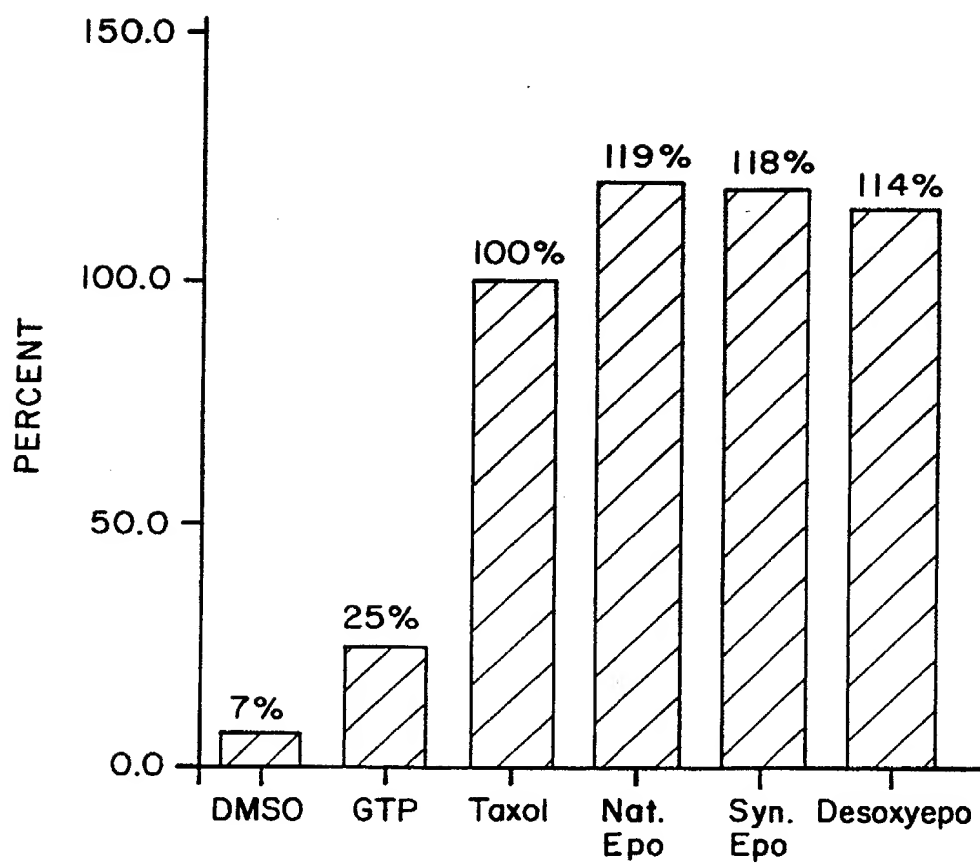
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FIG. 10



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FIG. 11



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FIG. 13

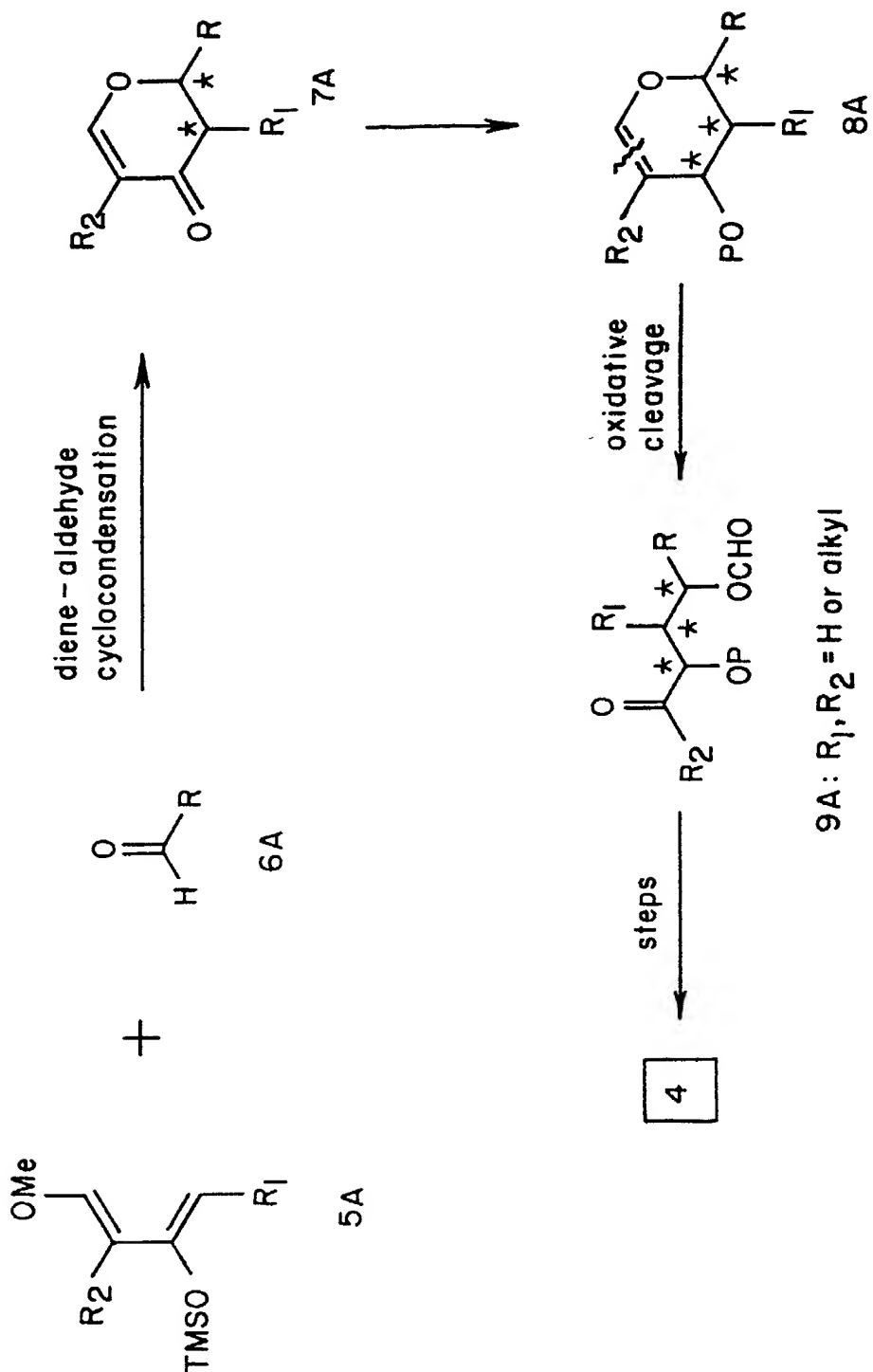
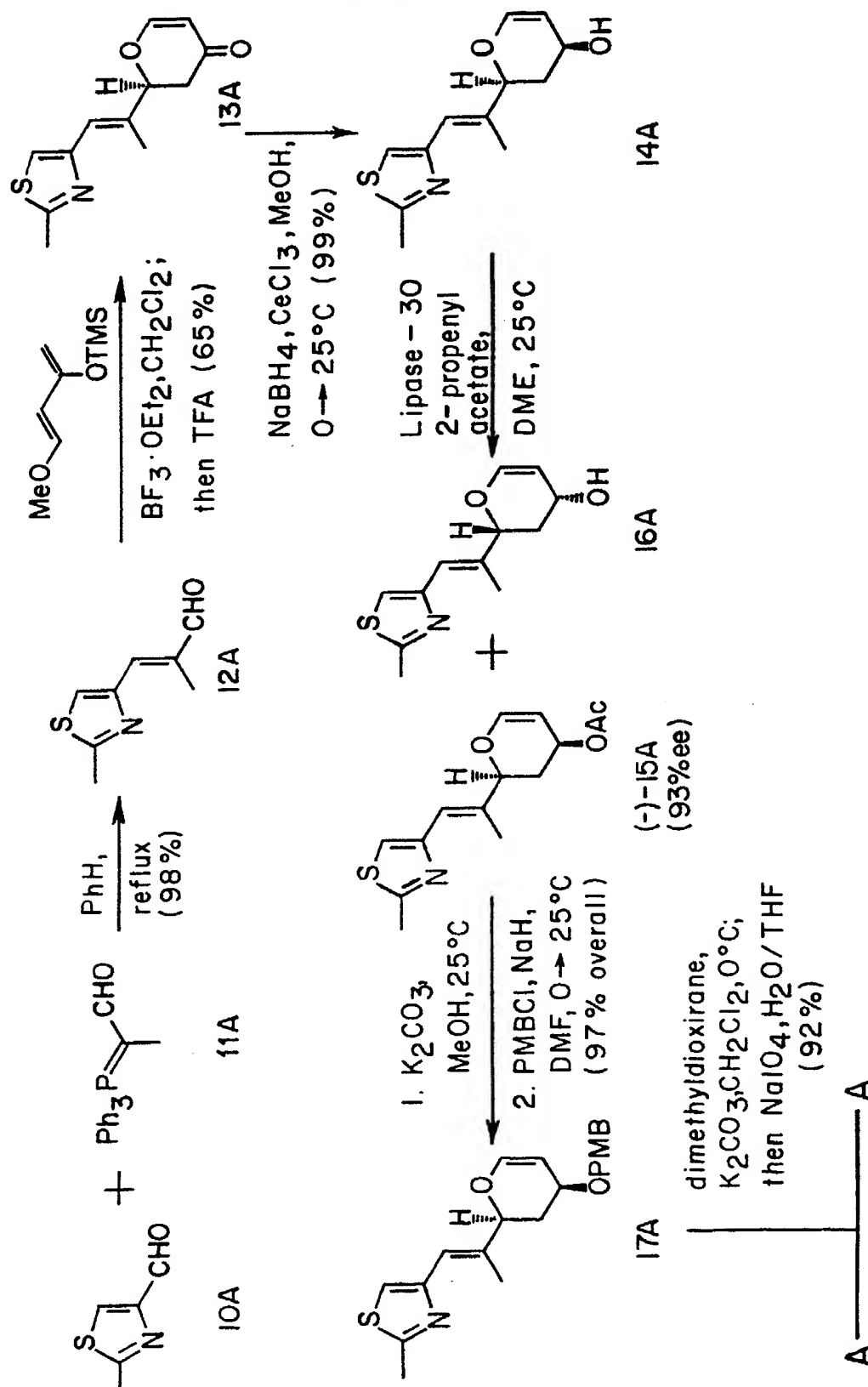


FIG. 14A



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FIG. 14B

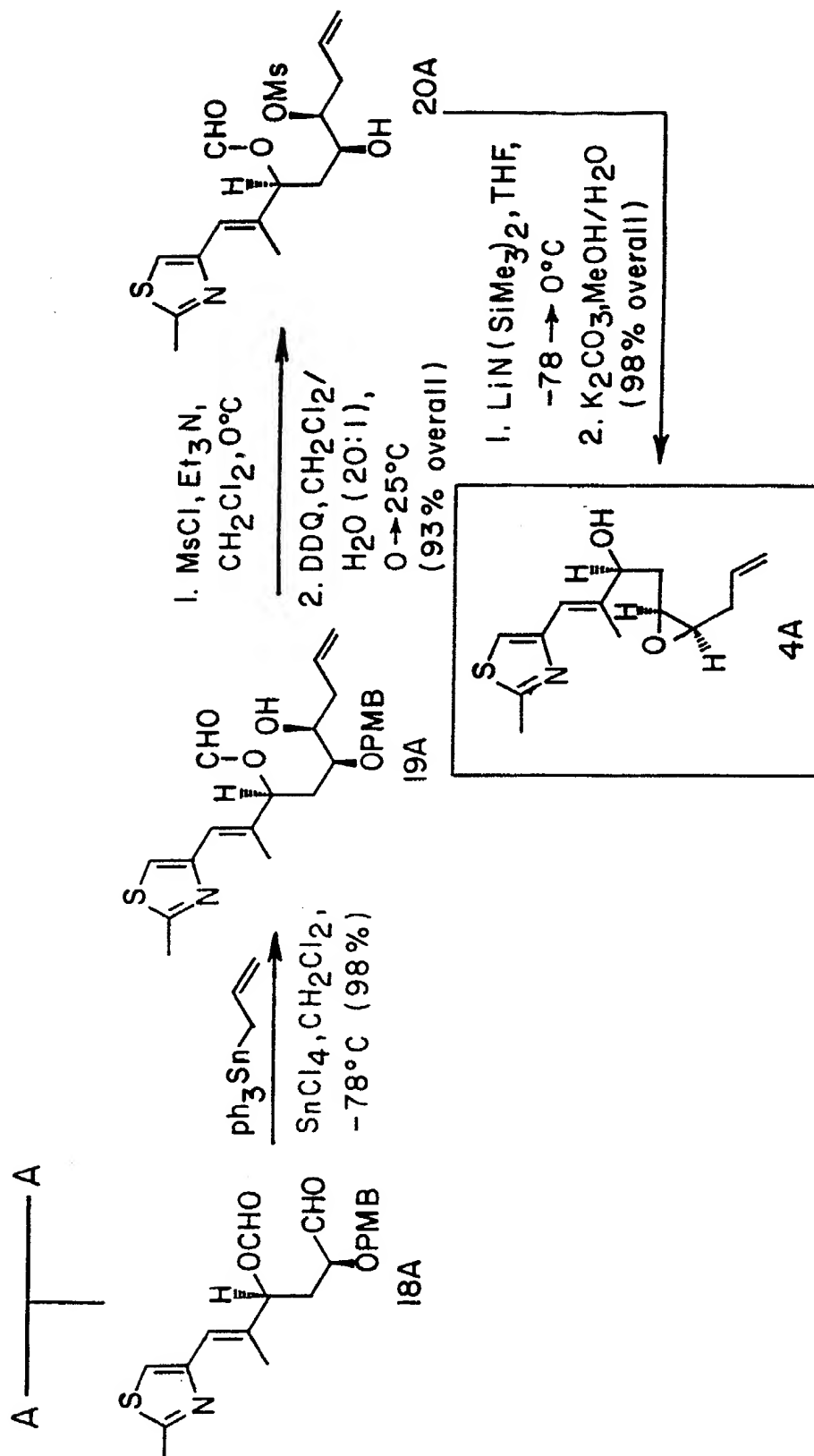
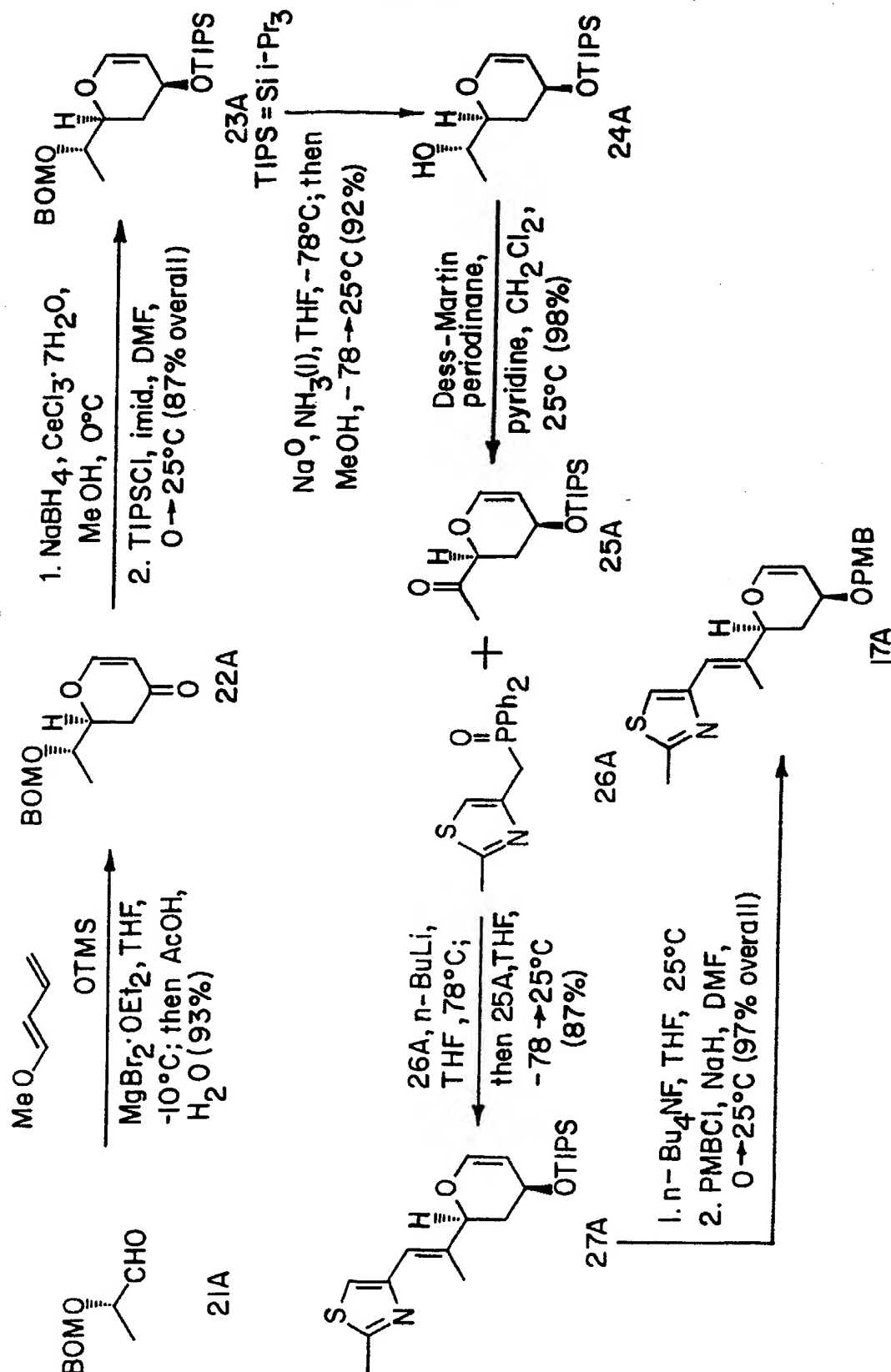
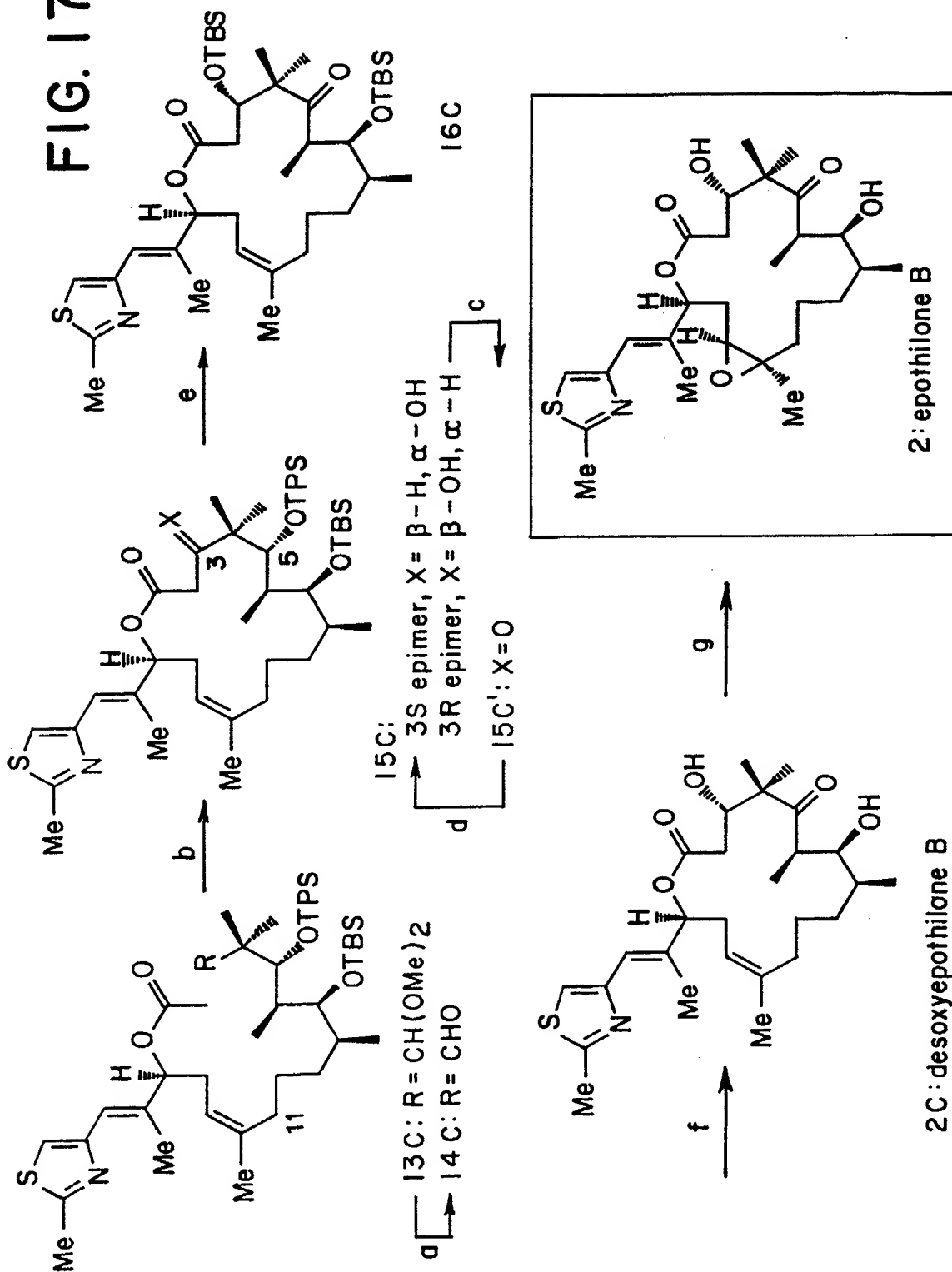


FIG. 15



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FIG. 17



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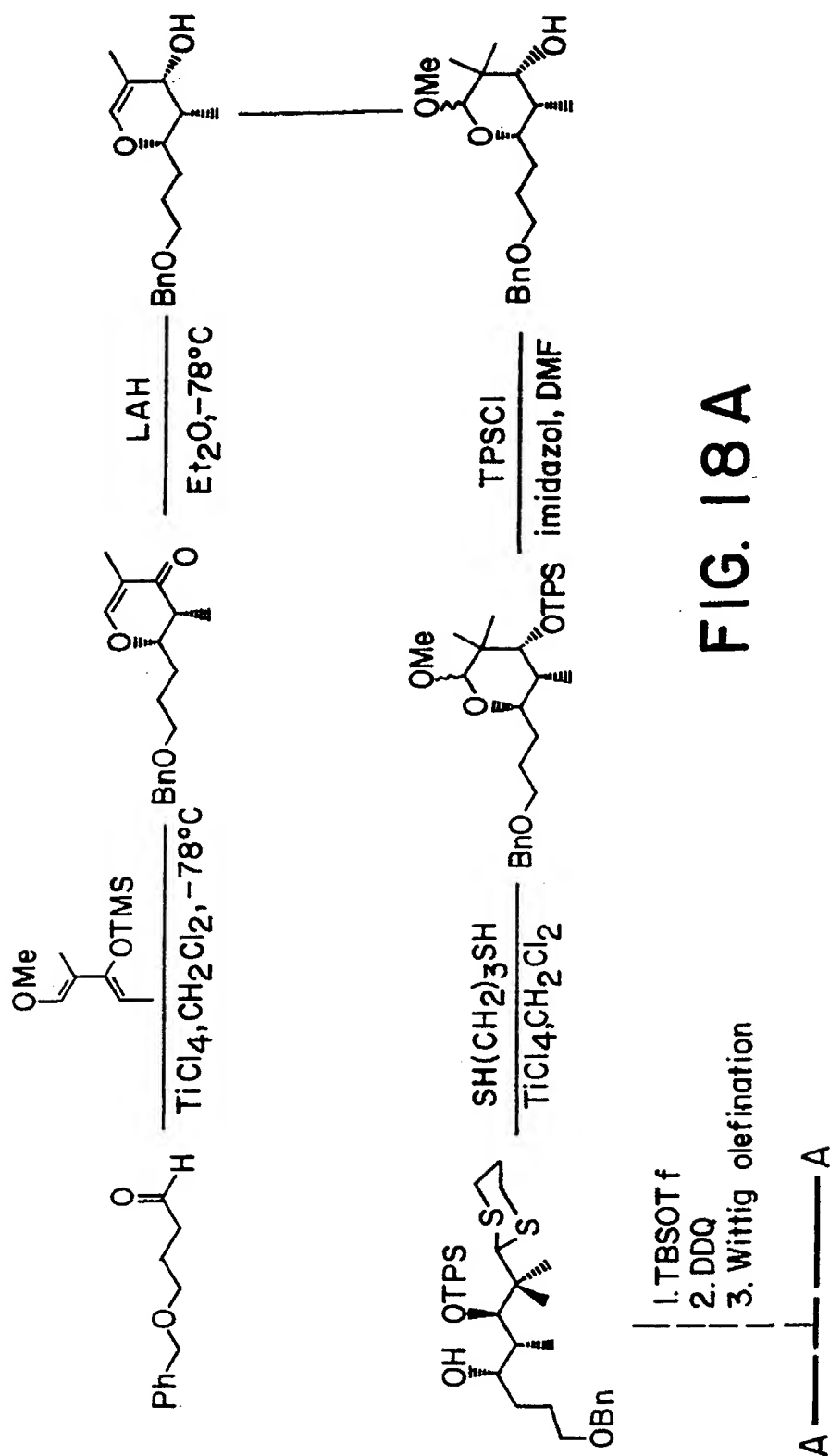
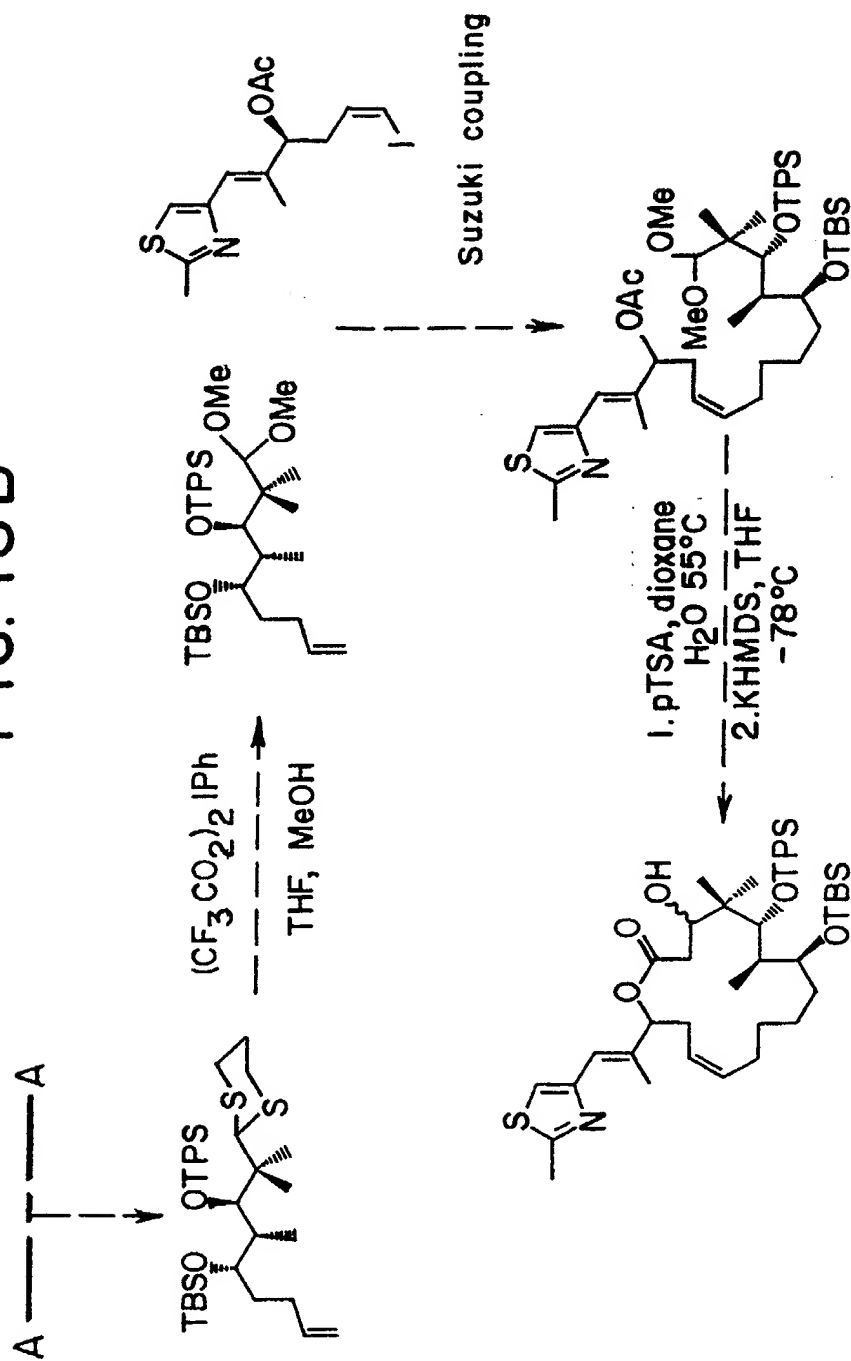


FIG. 18A

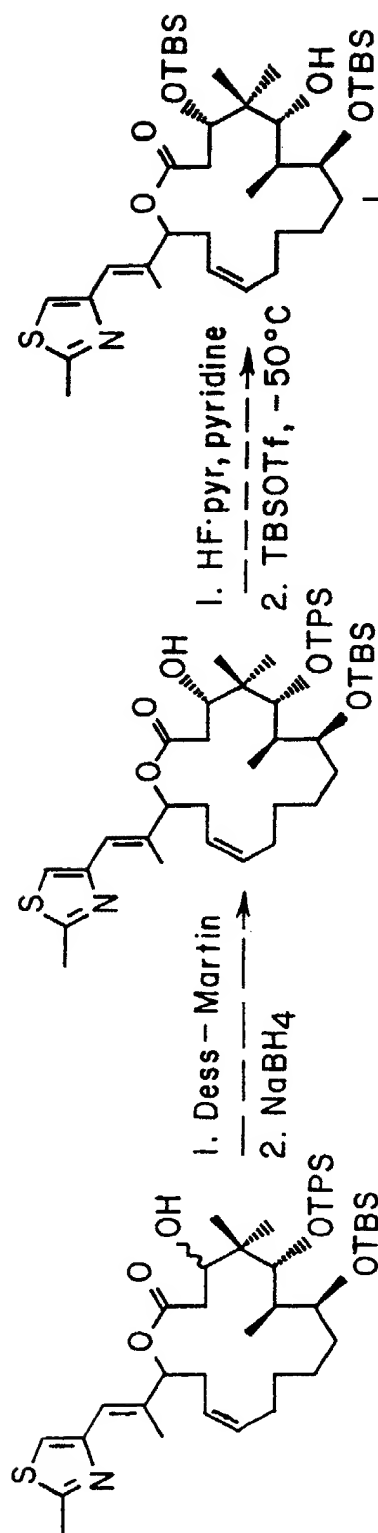
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FIG. 18B



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FIG. 19A



1. Dess Martin
periodinane

2. HF·pyr

FIG. 19B

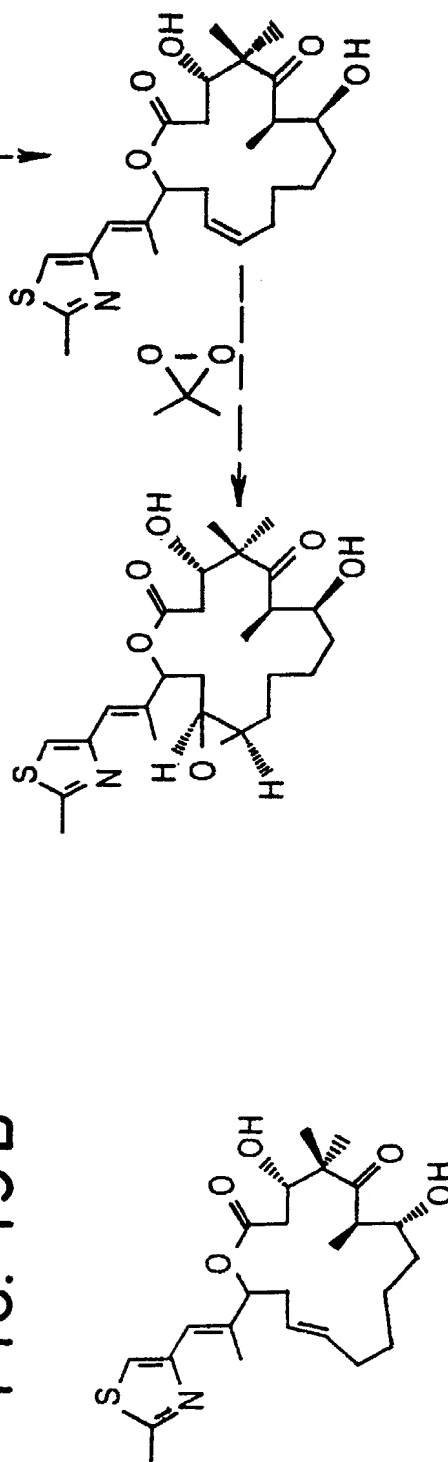


FIG. 19C

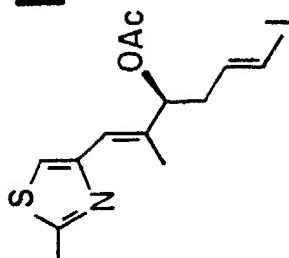
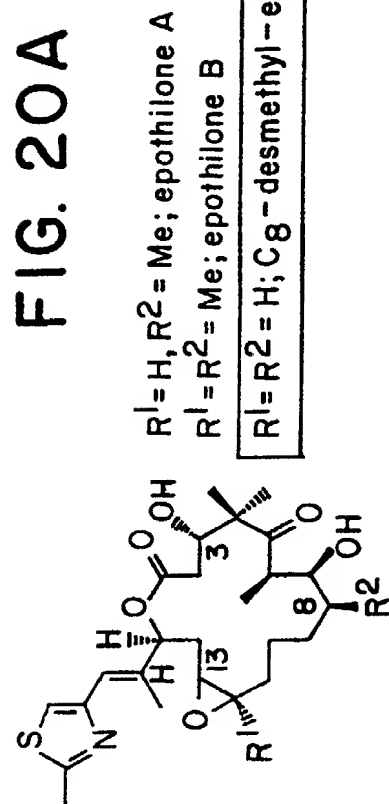


FIG. 20A


 $R^1 = H, R^2 = \text{Me}; \text{epothilone A}$
 $R^1 = R^2 = \text{Me}; \text{epothilone B}$
 $R^1 = R^2 = H; \text{Cg-desmethyl-epothilone A (3D)}$

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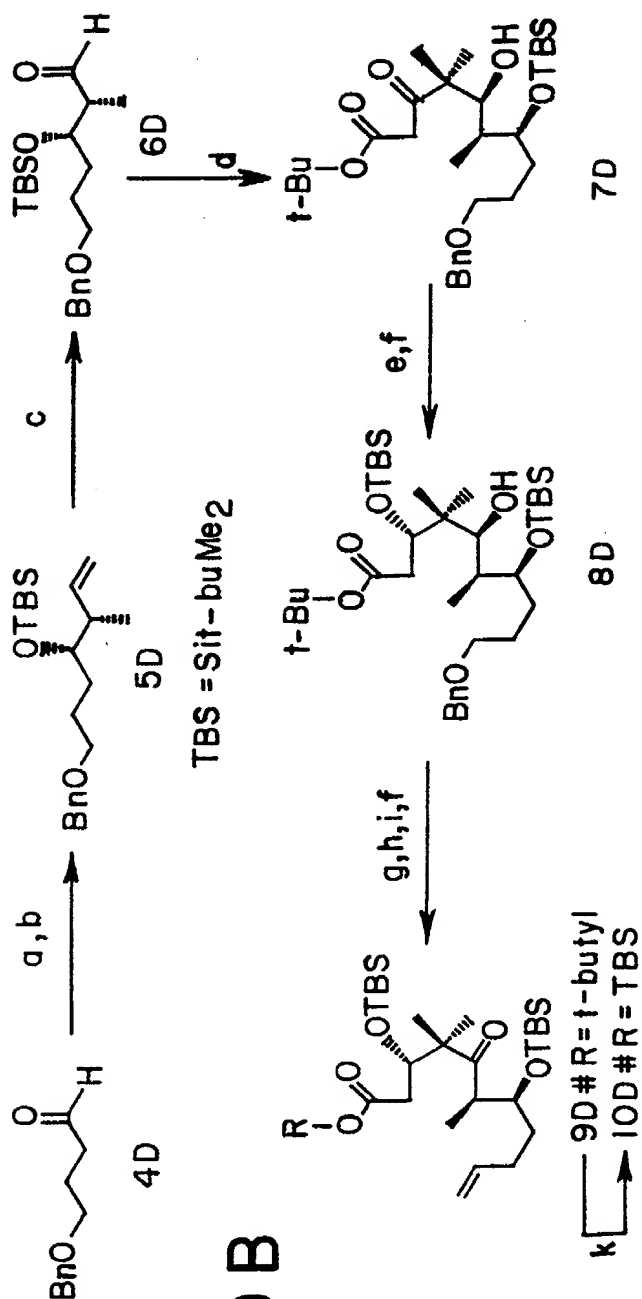
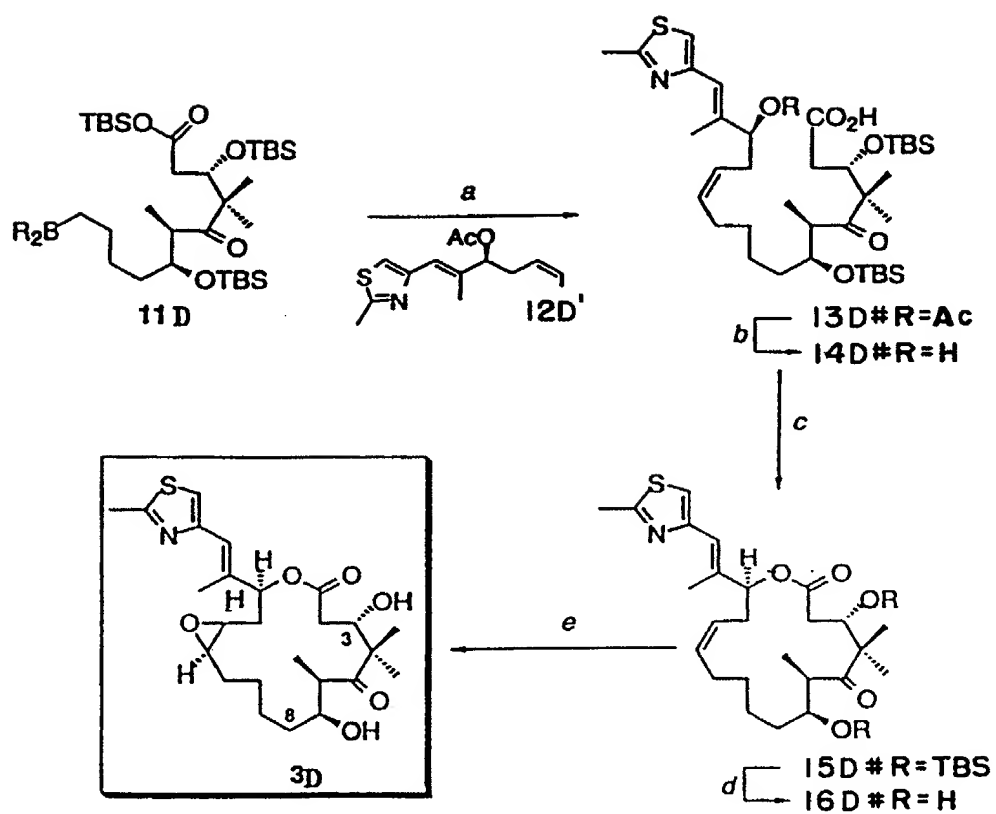


FIG. 20B

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FIG. 21



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FIG. 22 A

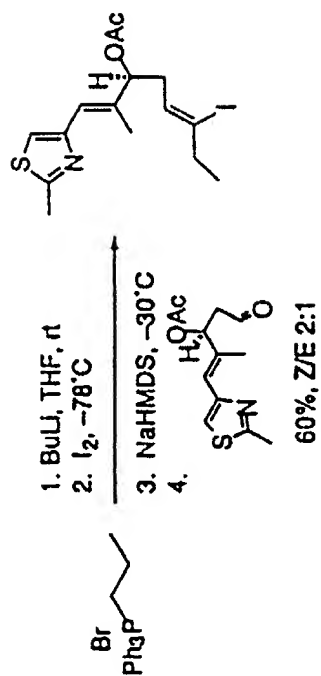
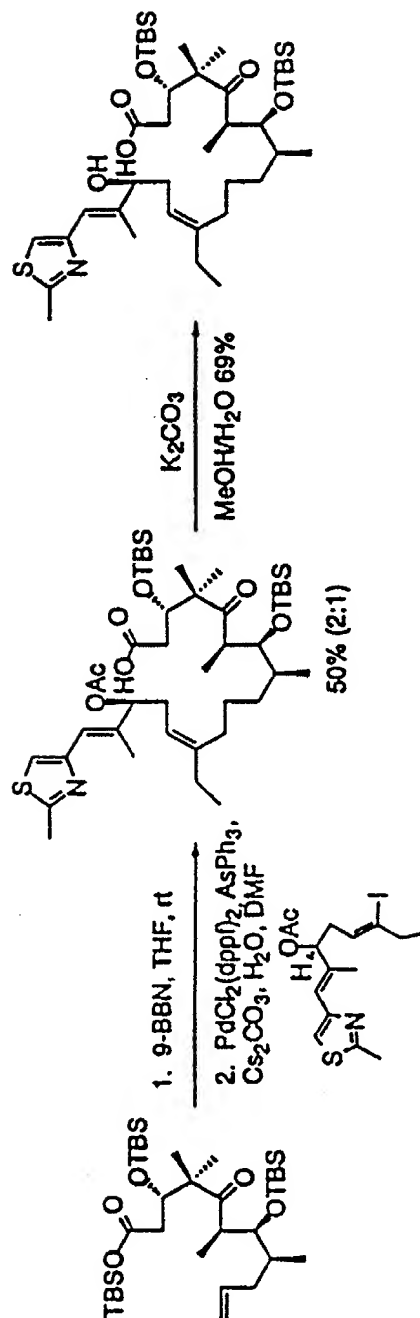
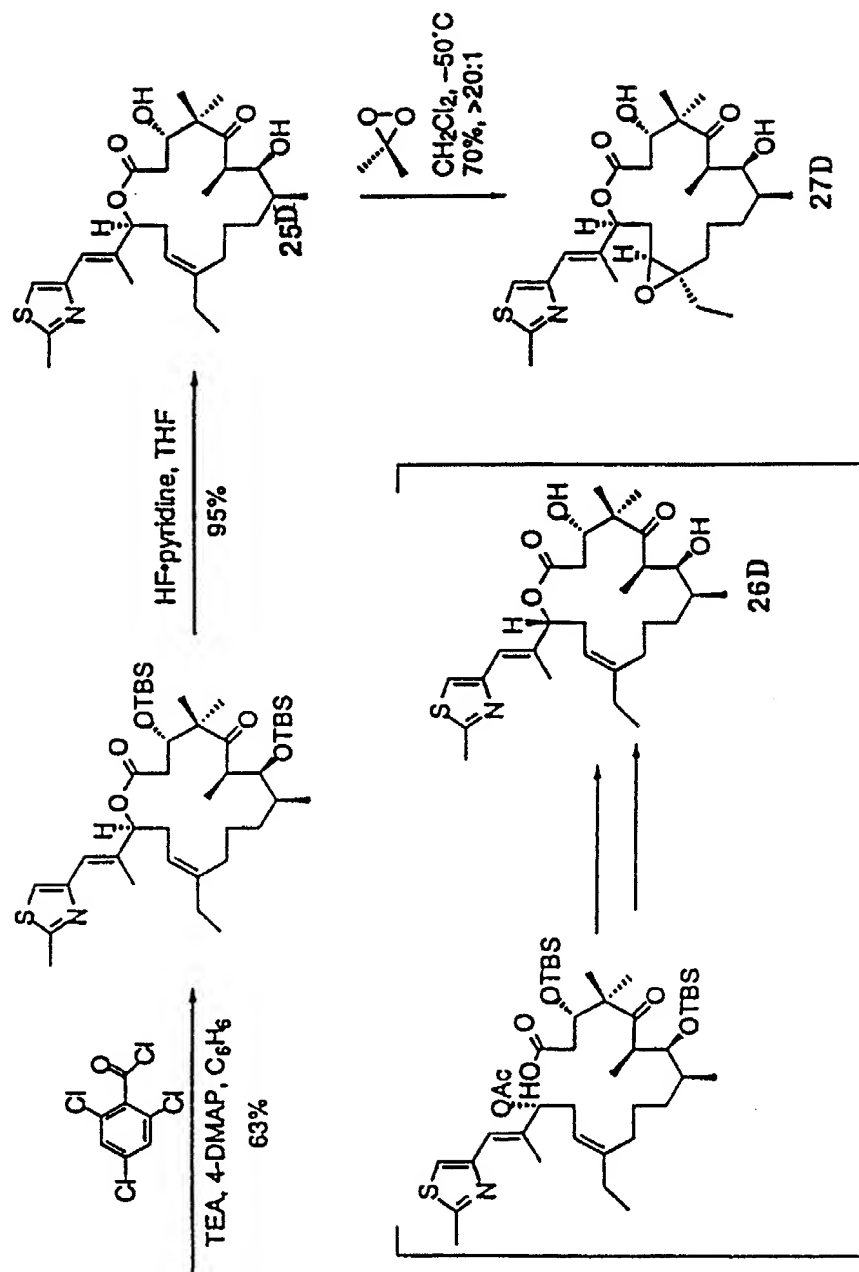


FIG. 22 B



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FIG. 22C



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FIG. 23A

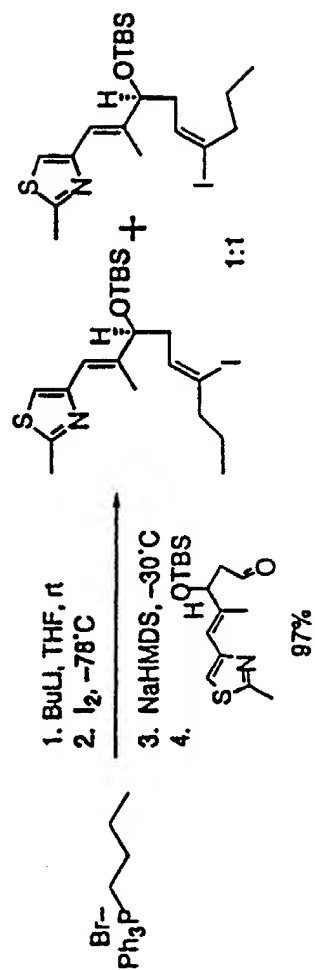
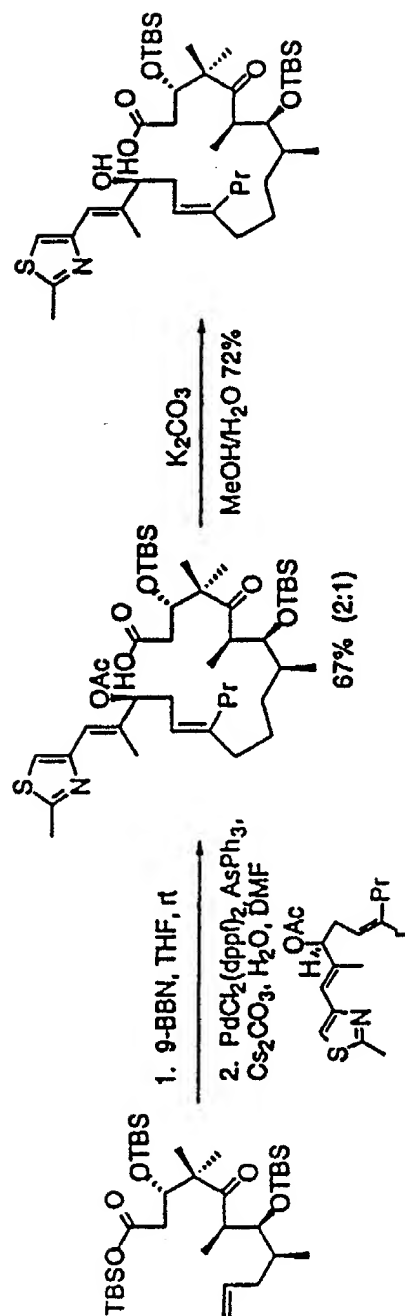
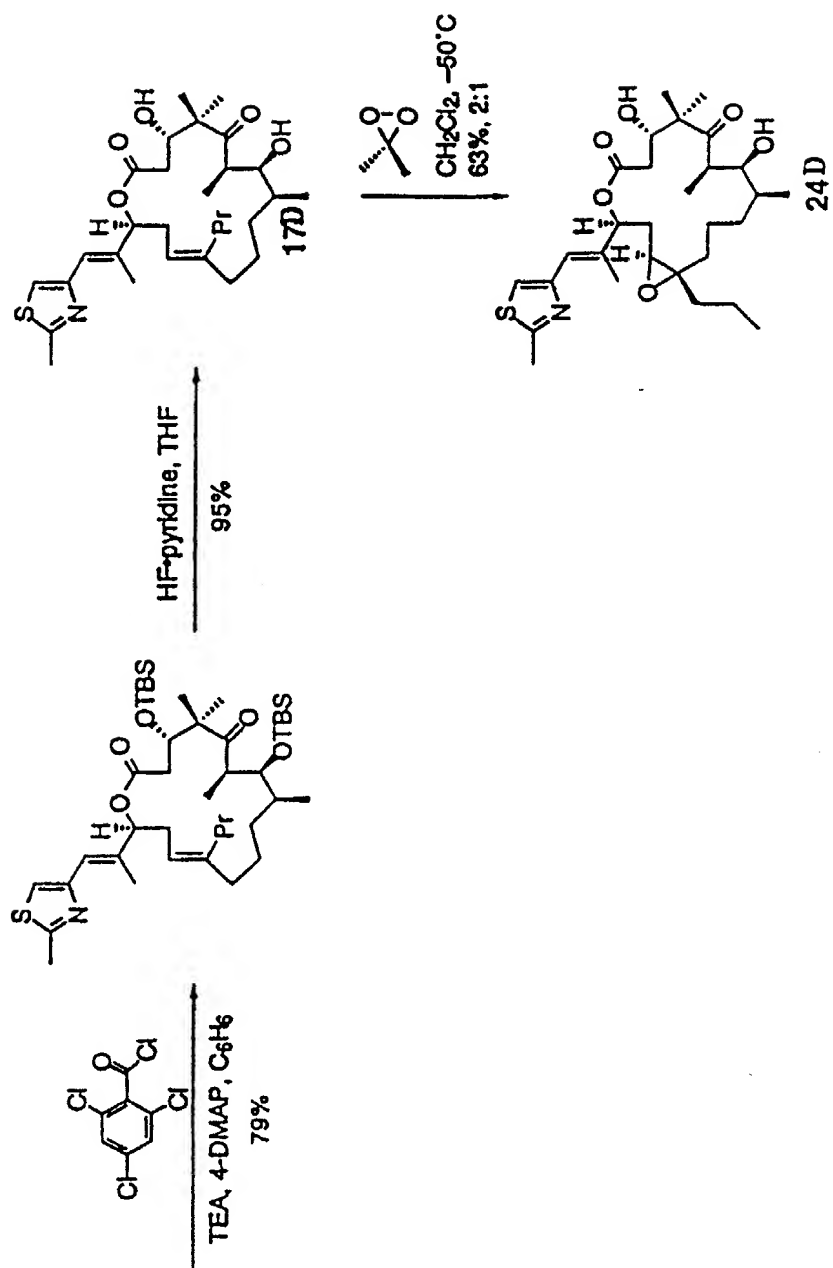


FIG. 23B



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FIG. 23C



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FIG. 24A

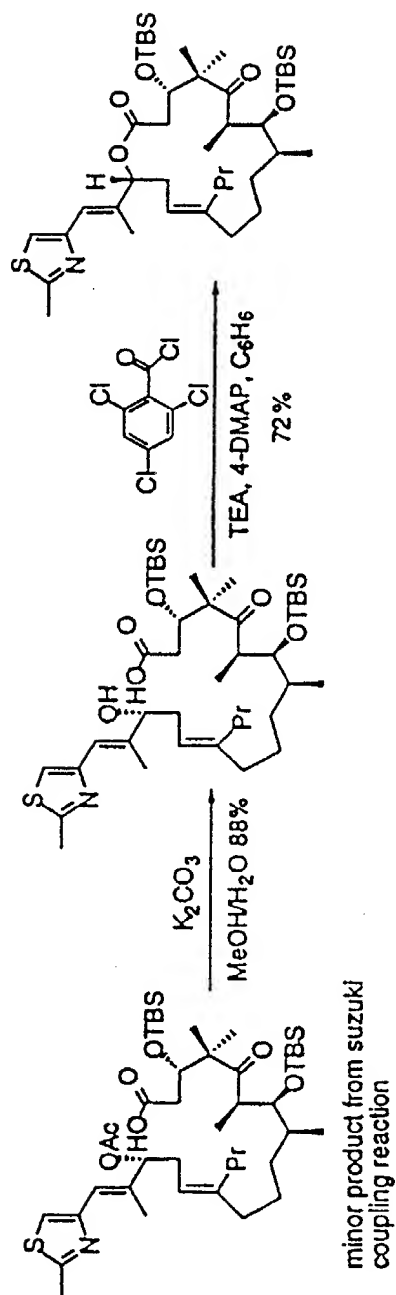
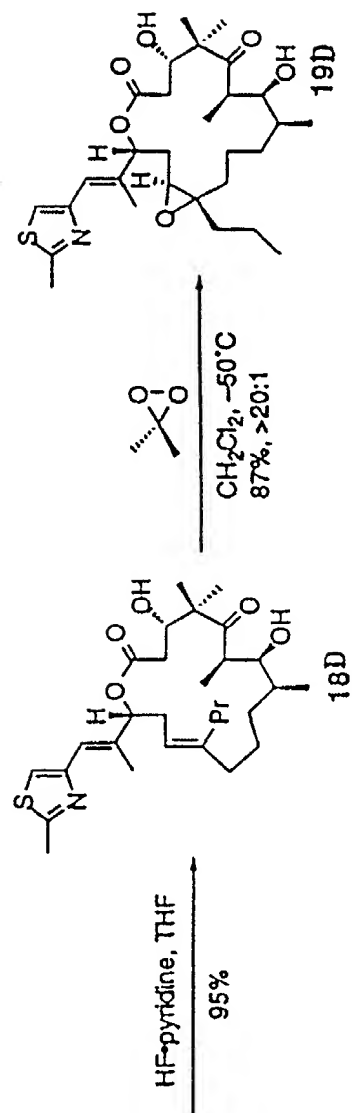


FIG. 24B



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FIG. 25A

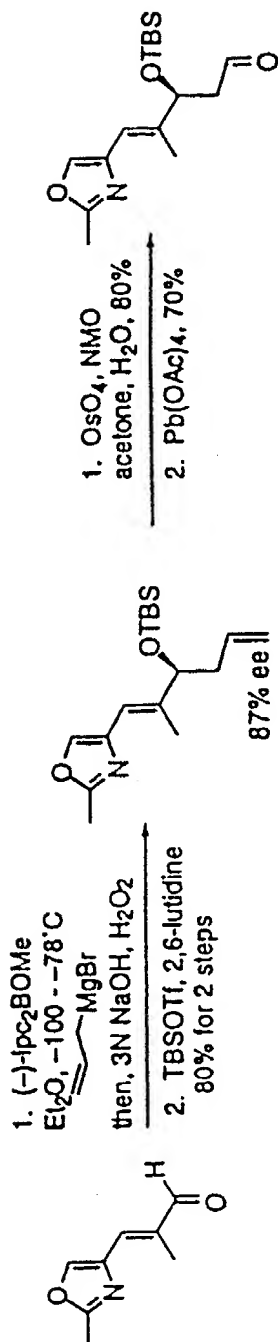
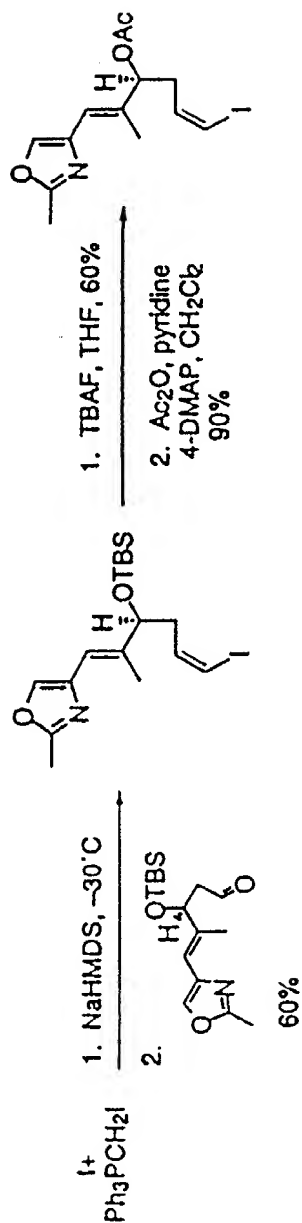


FIG. 25B



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FIG. 25C

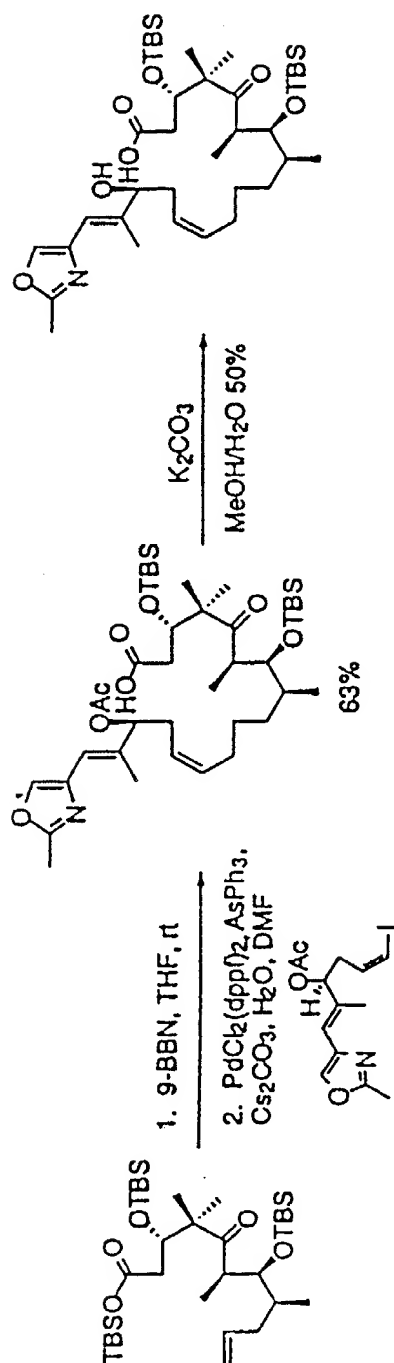
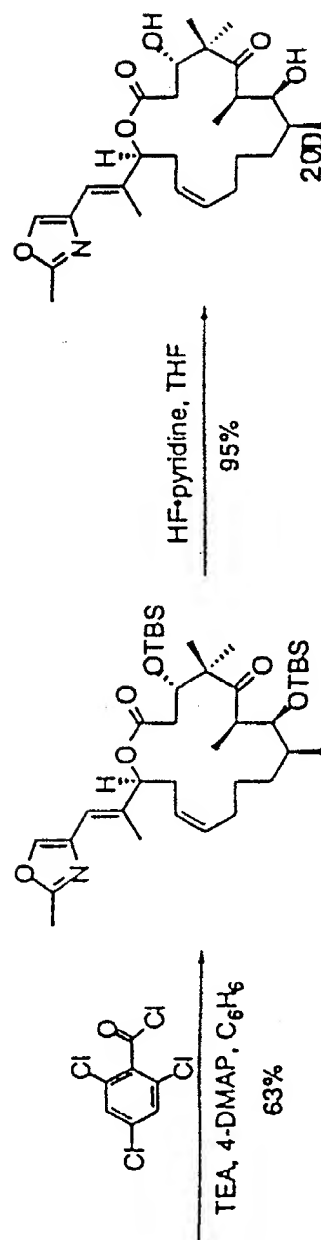


FIG. 25D



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FIG. 26A

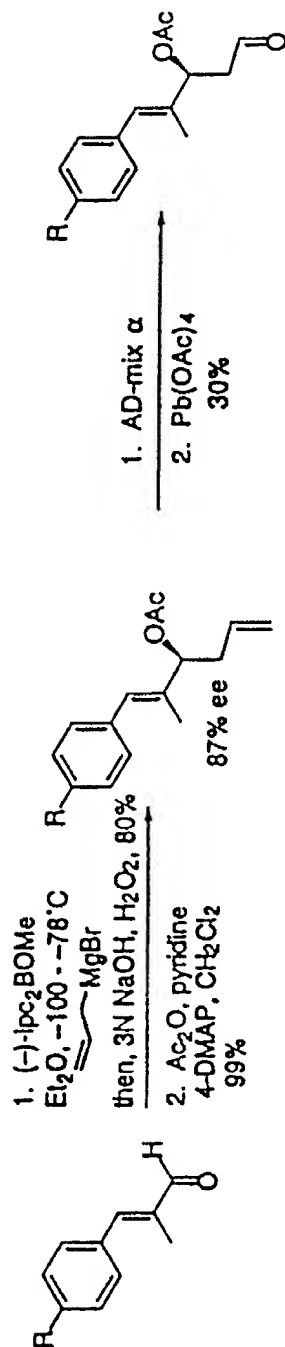
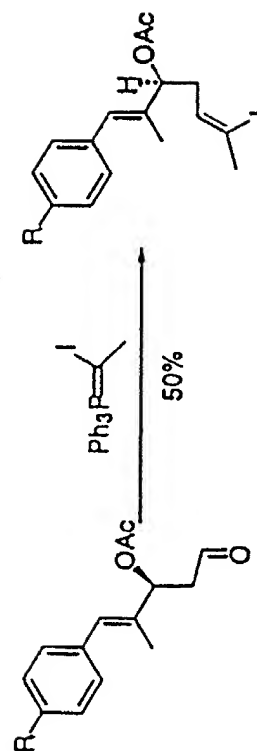


FIG. 26B



R = H, F, CF_3
 R=H is the only compound
 completed, F and CF_3 are nearly
 completed

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FIG. 26C

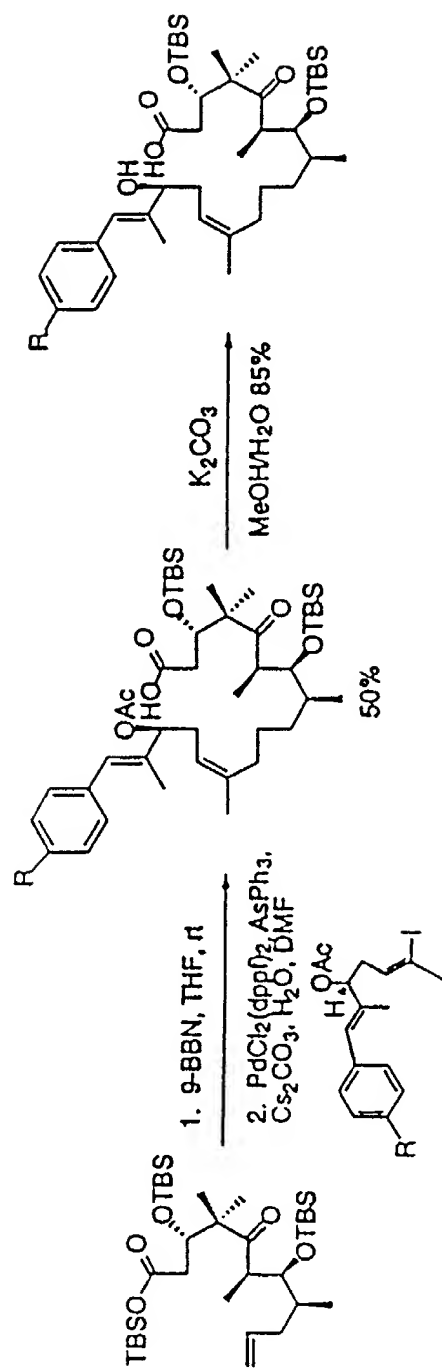
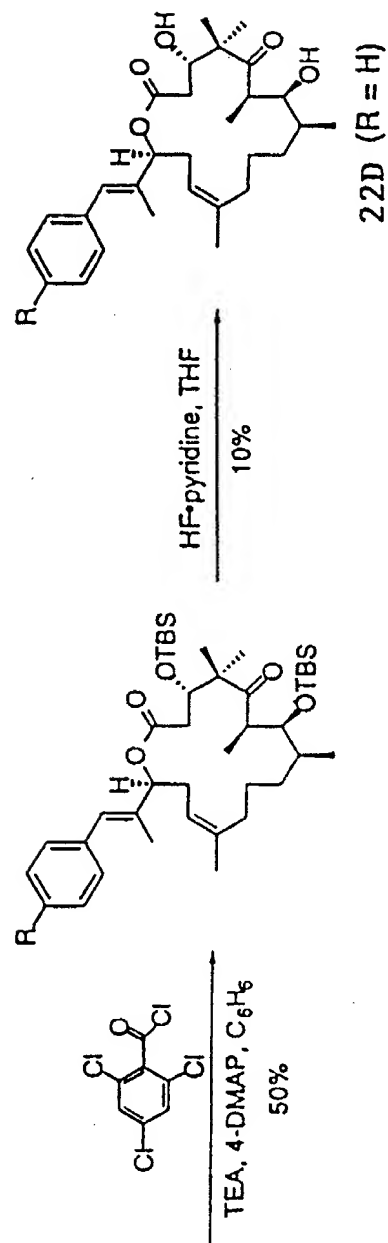
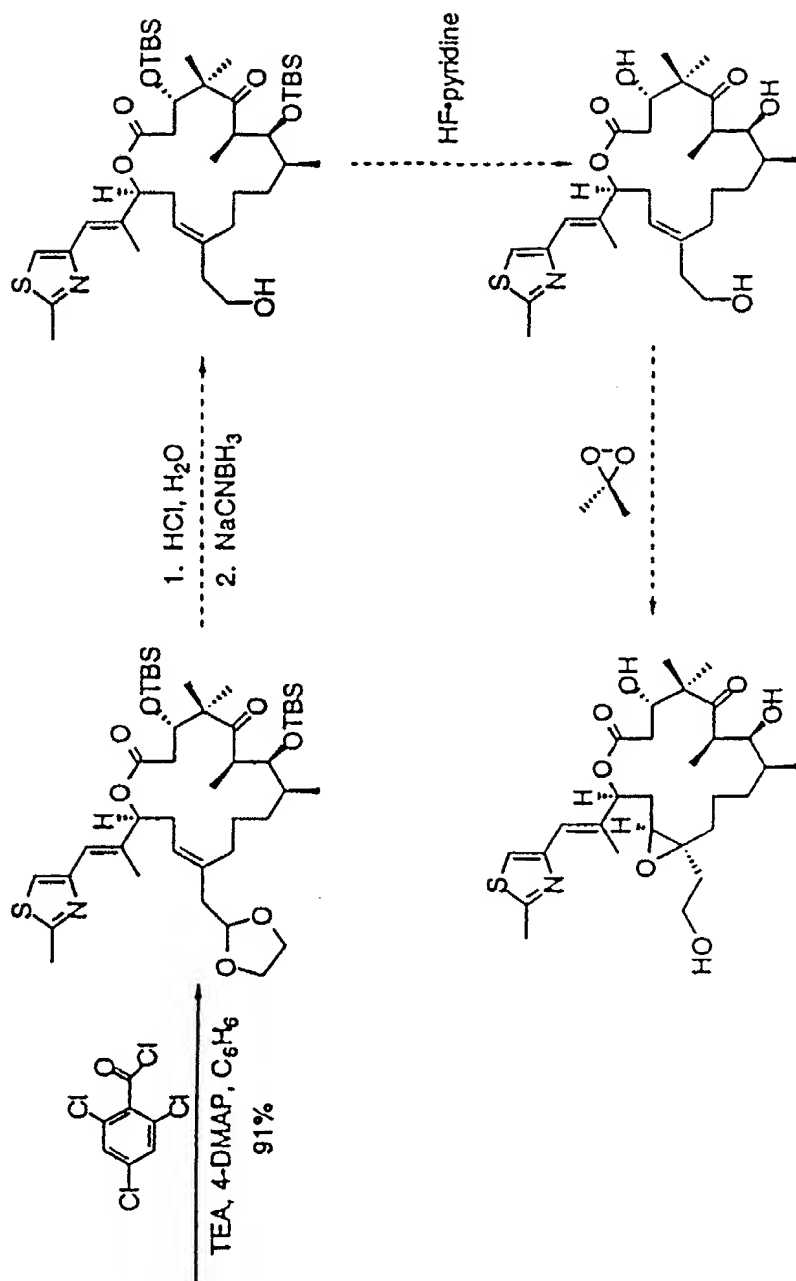


FIG. 26D



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FIG. 27C



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FIG. 28A

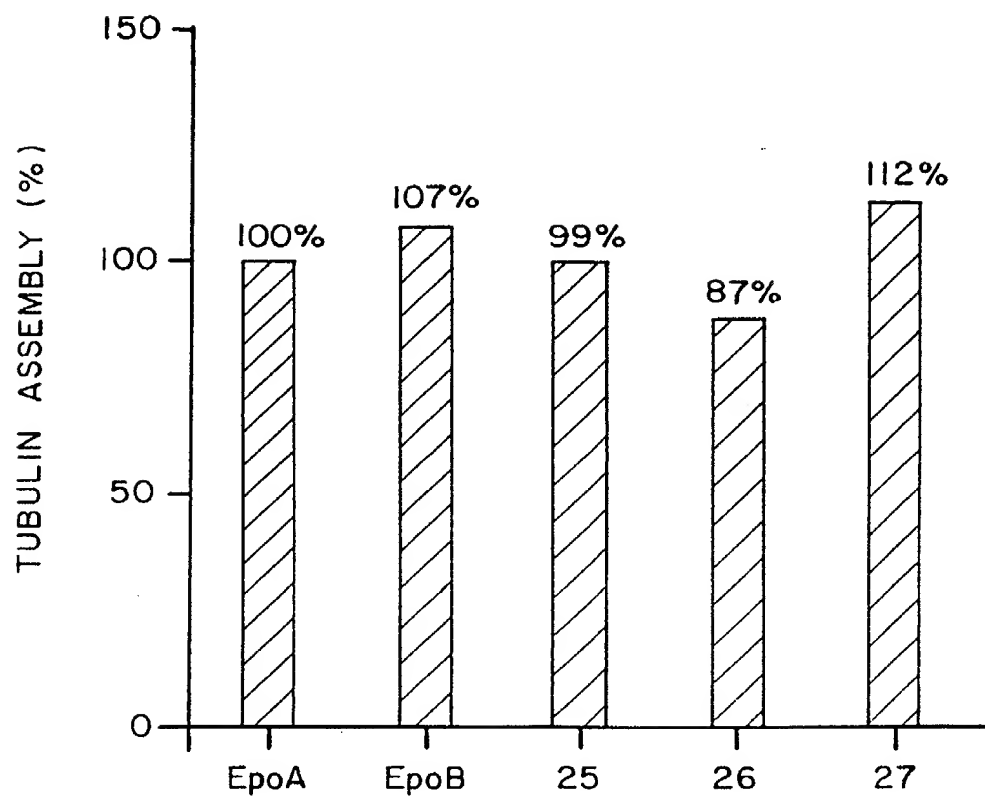
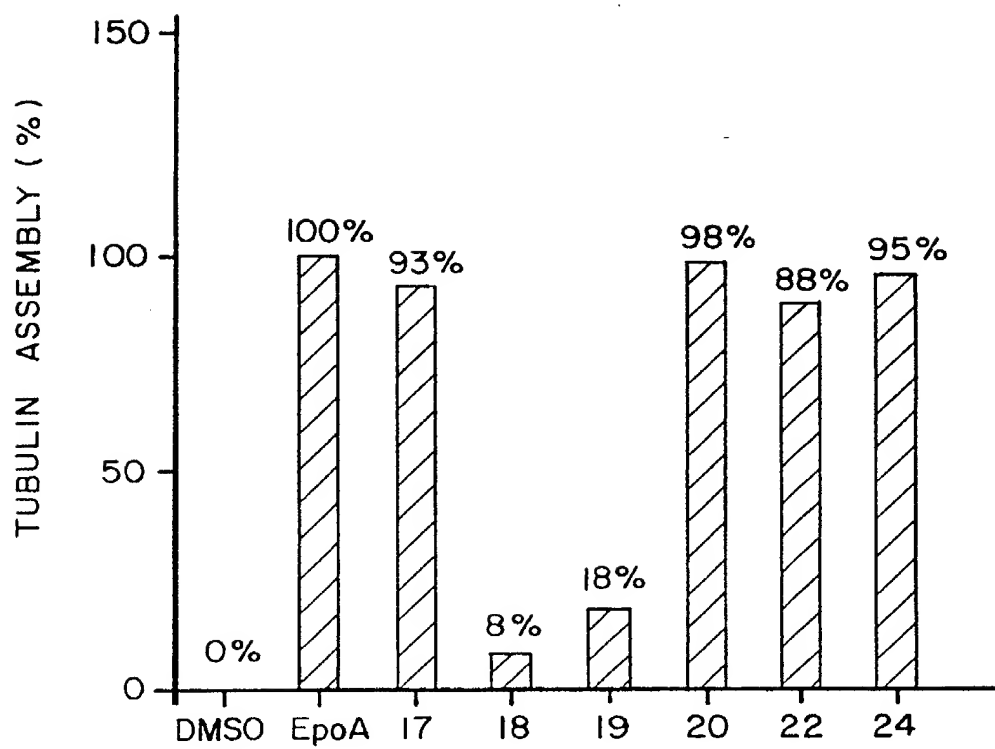
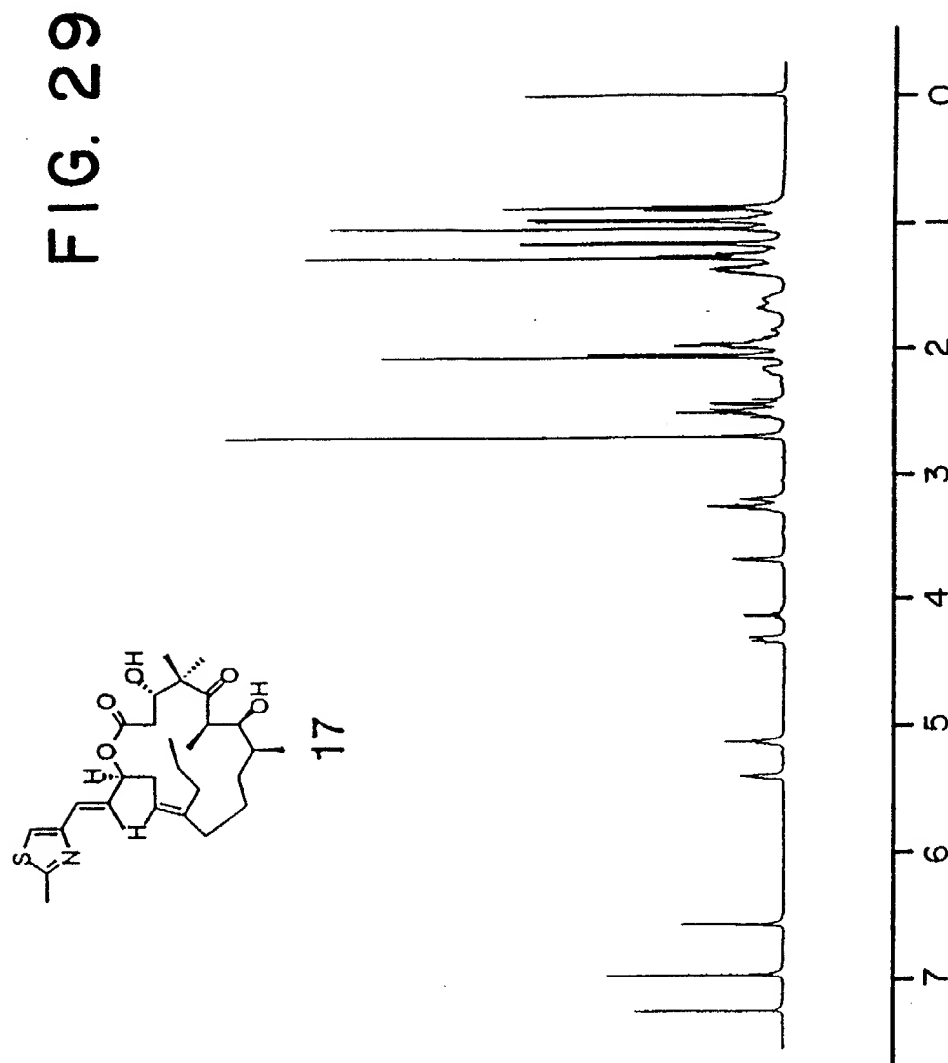


FIG. 28B

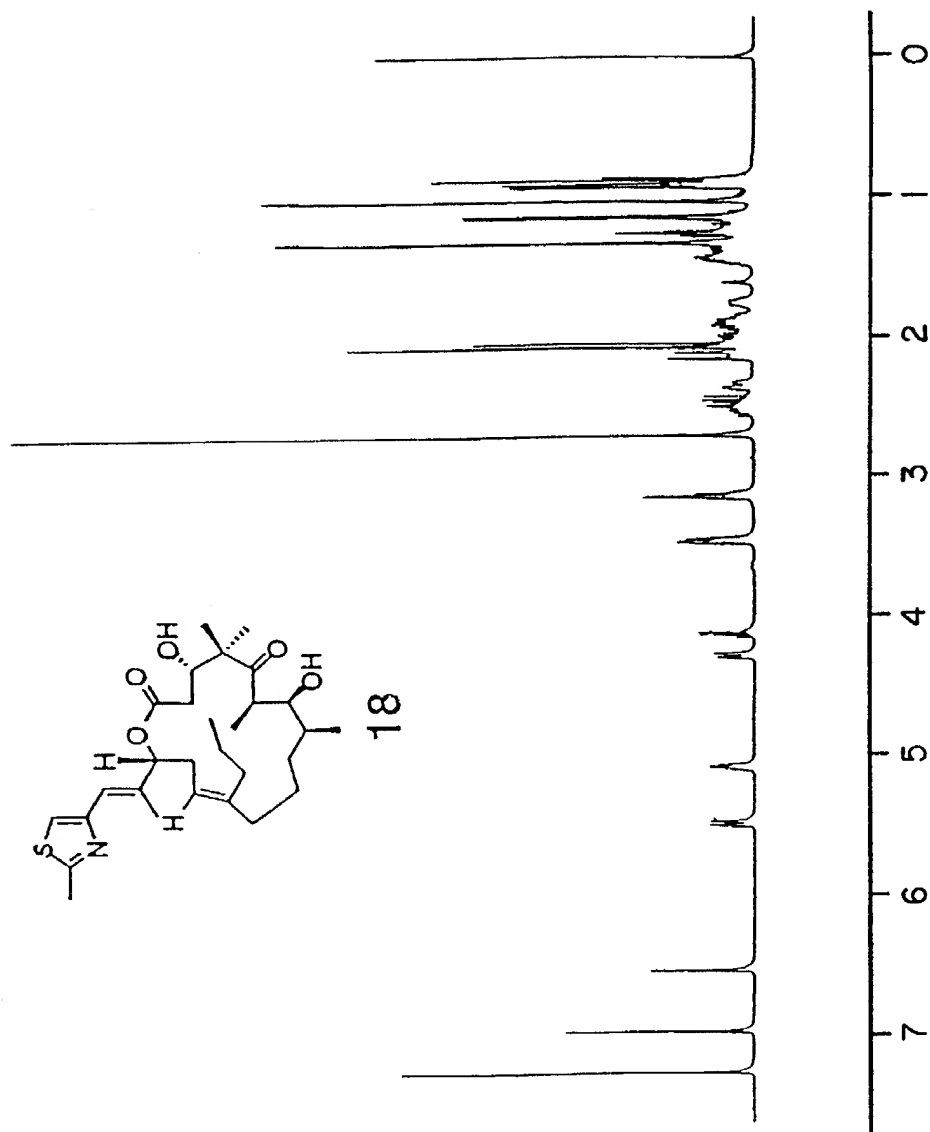


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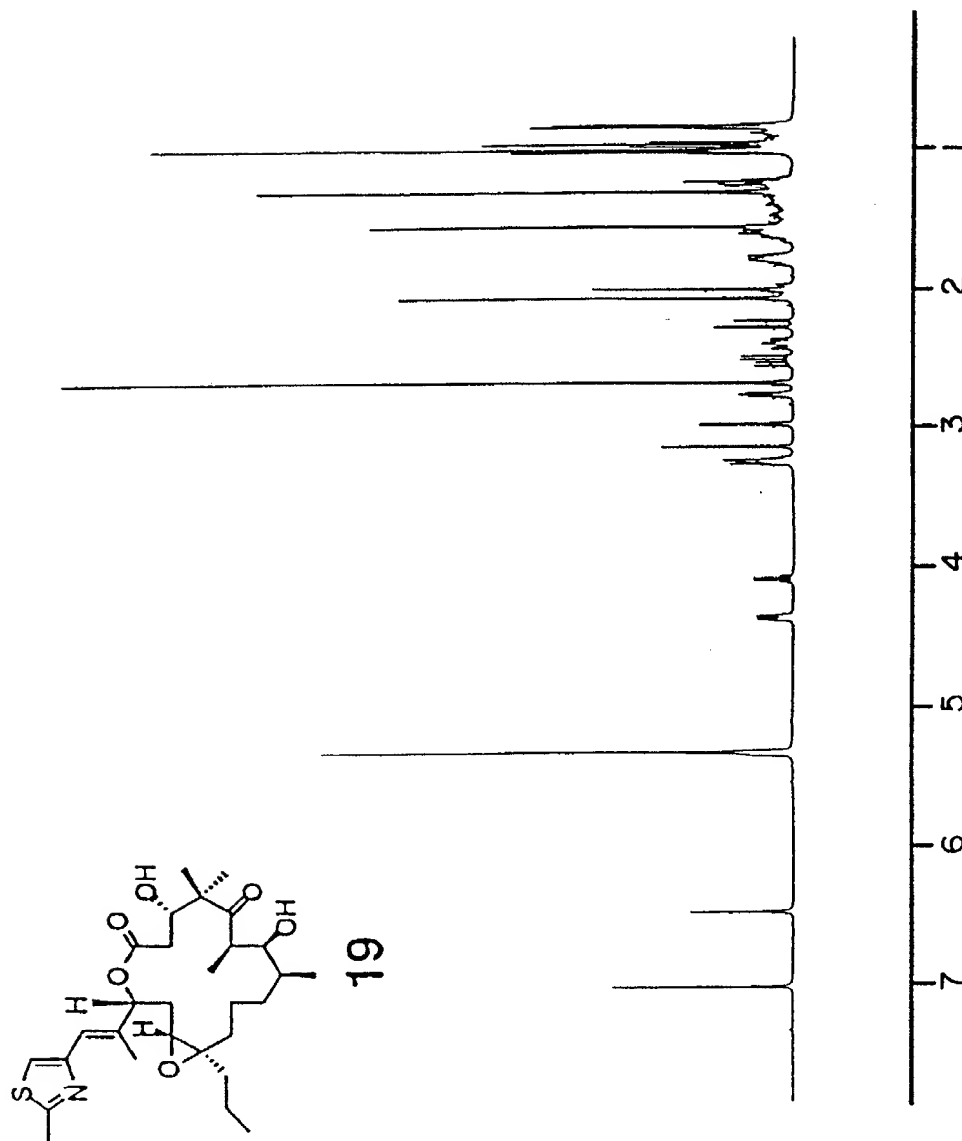
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FIG. 30



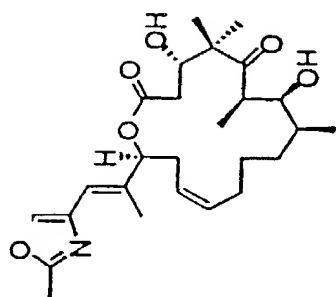
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FIG. 31

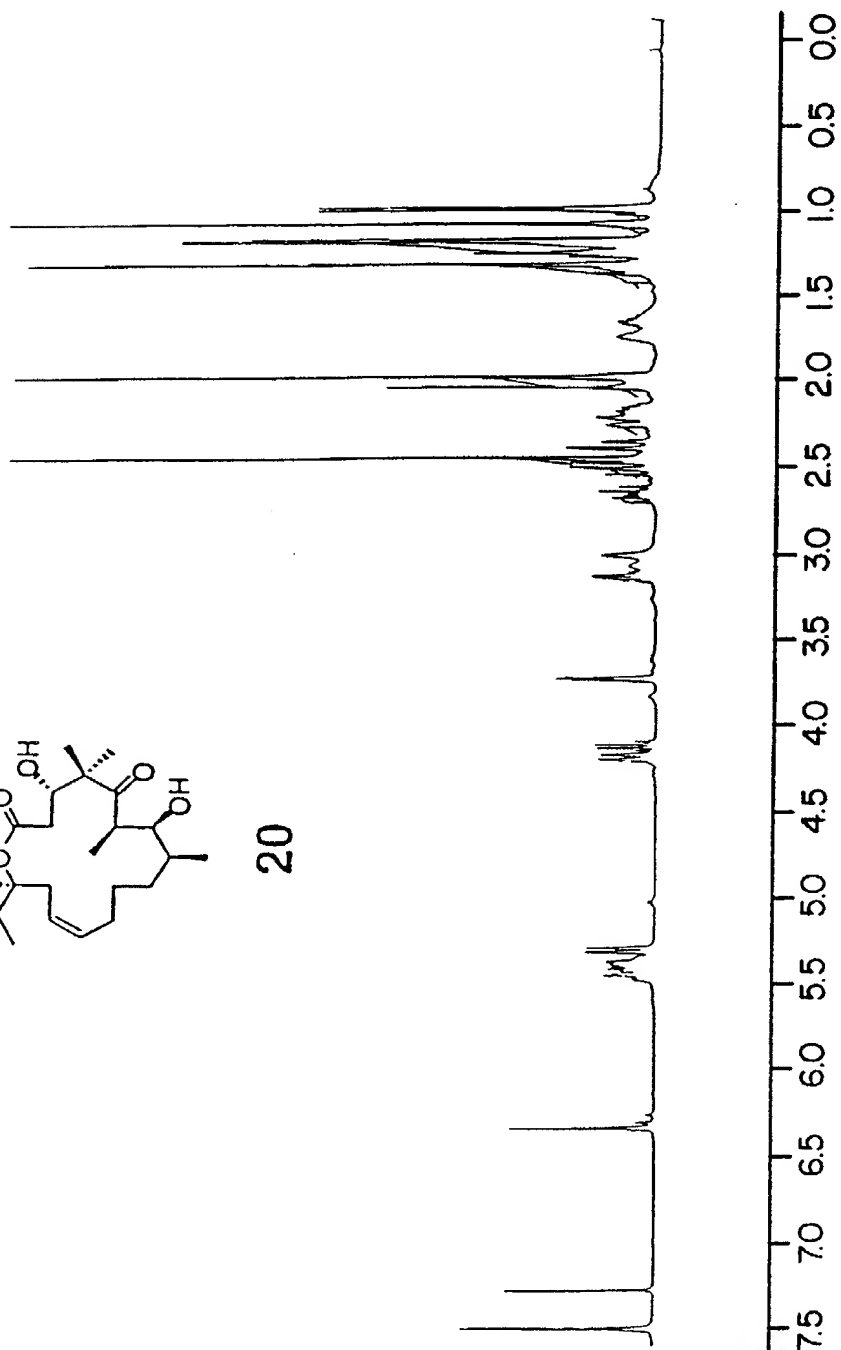


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FIG. 32

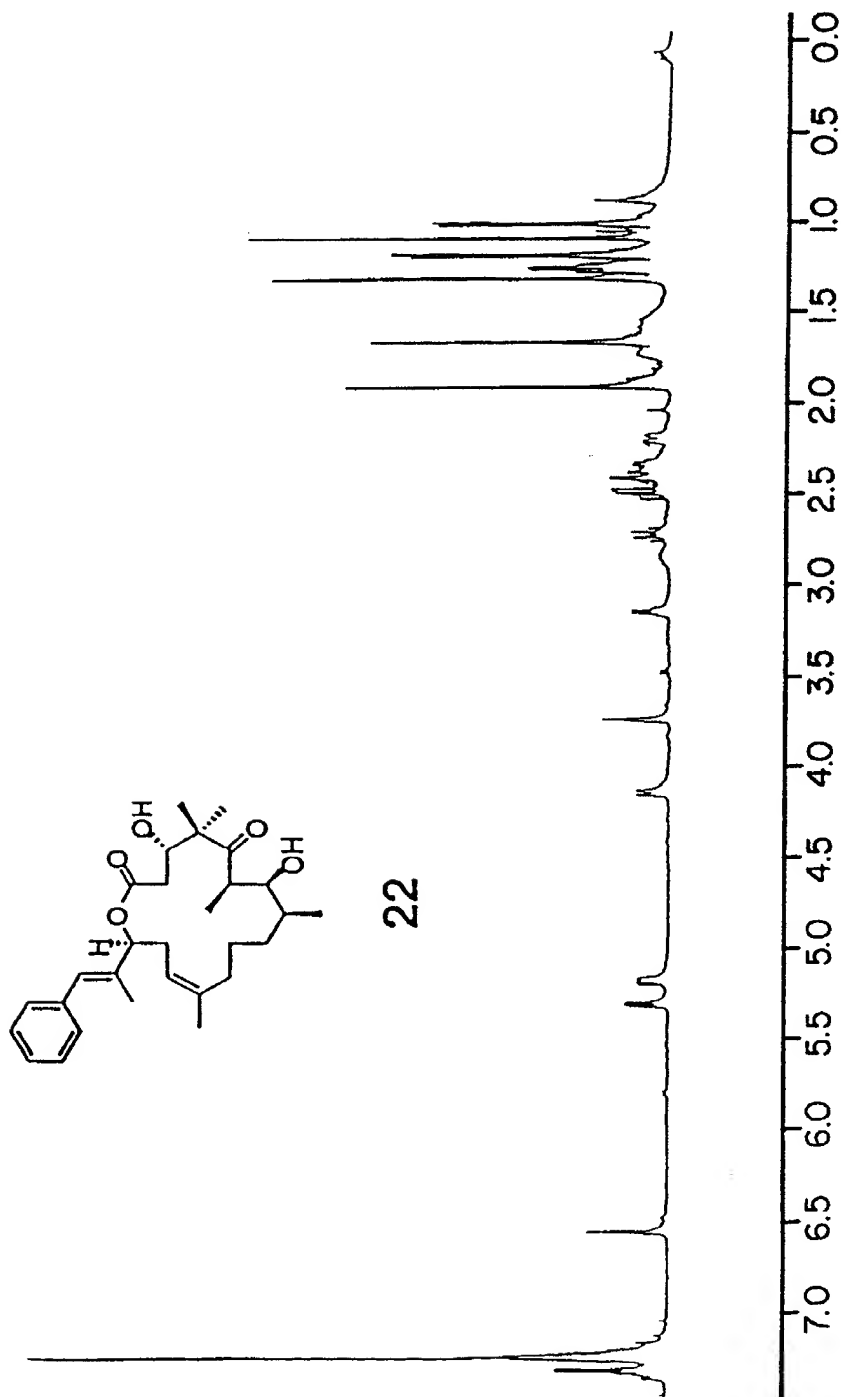


20

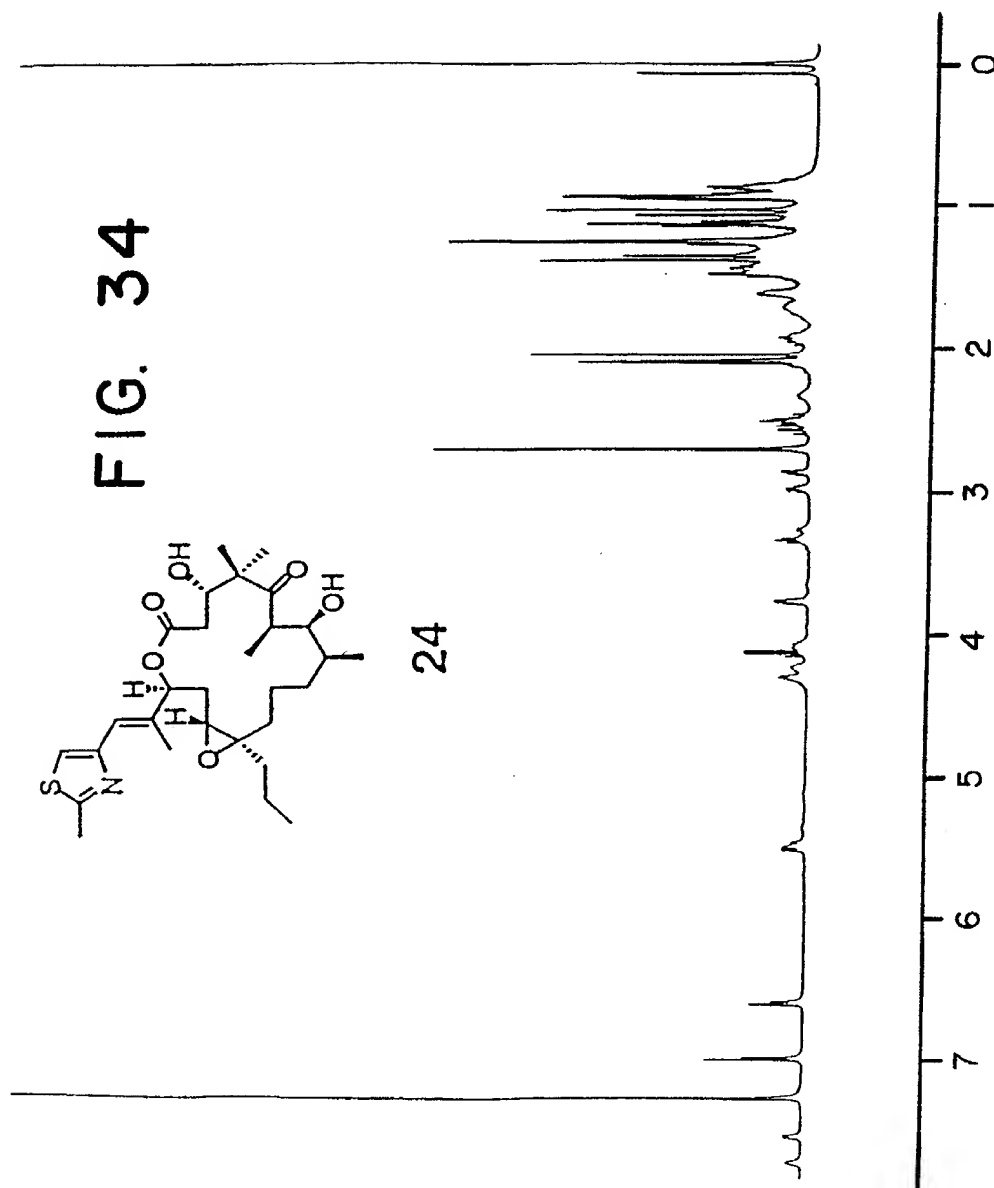


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FIG. 33

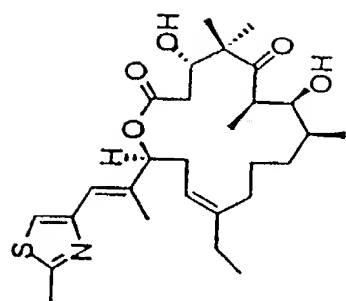


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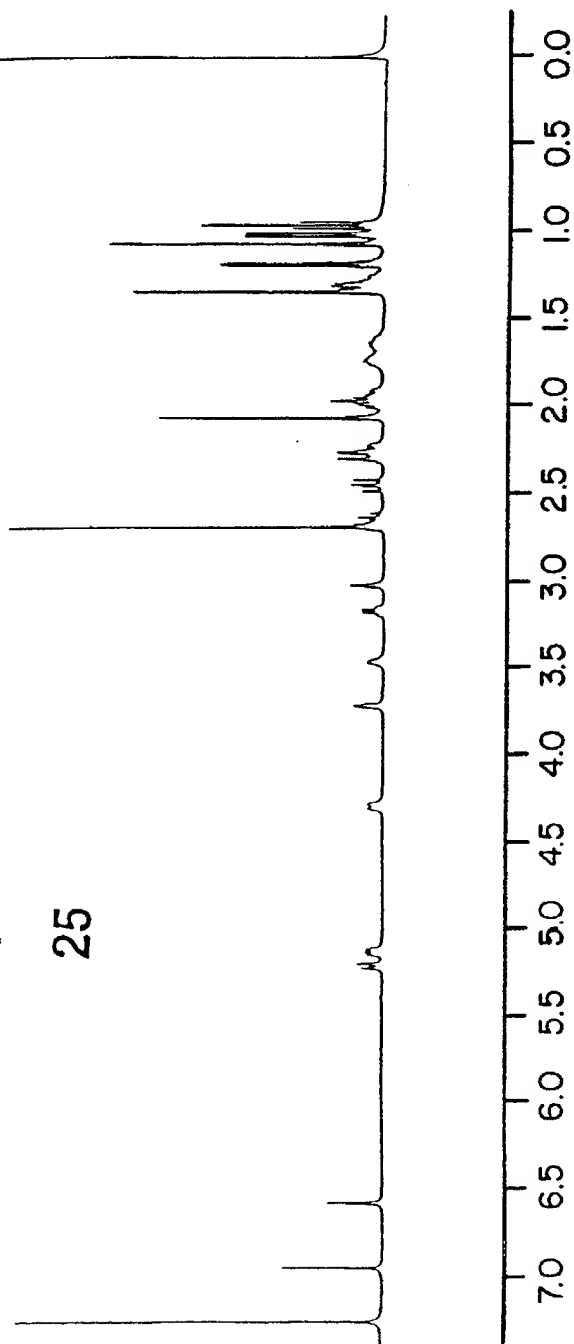


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FIG. 35



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FIG. 36

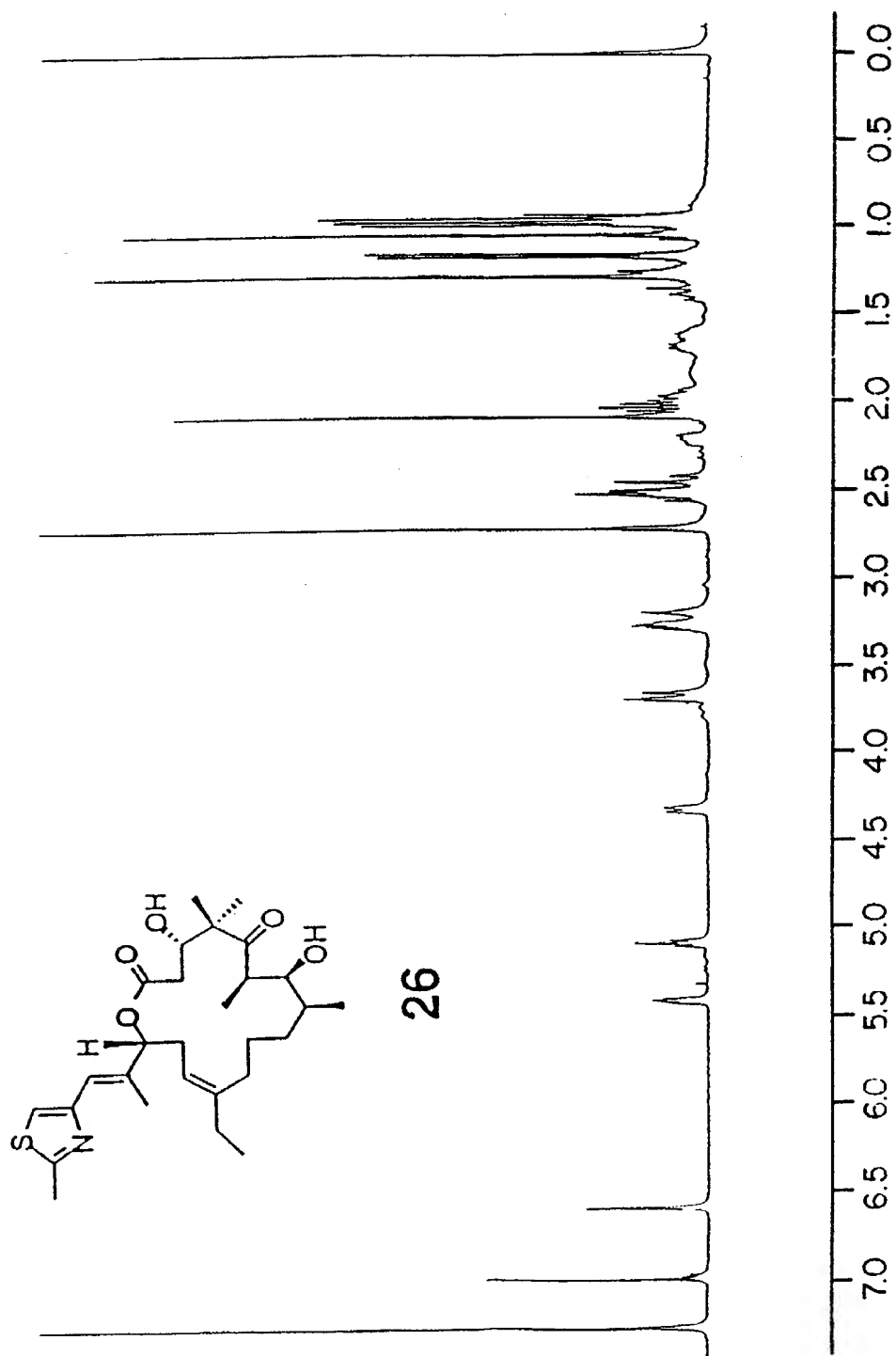


FIG. 37

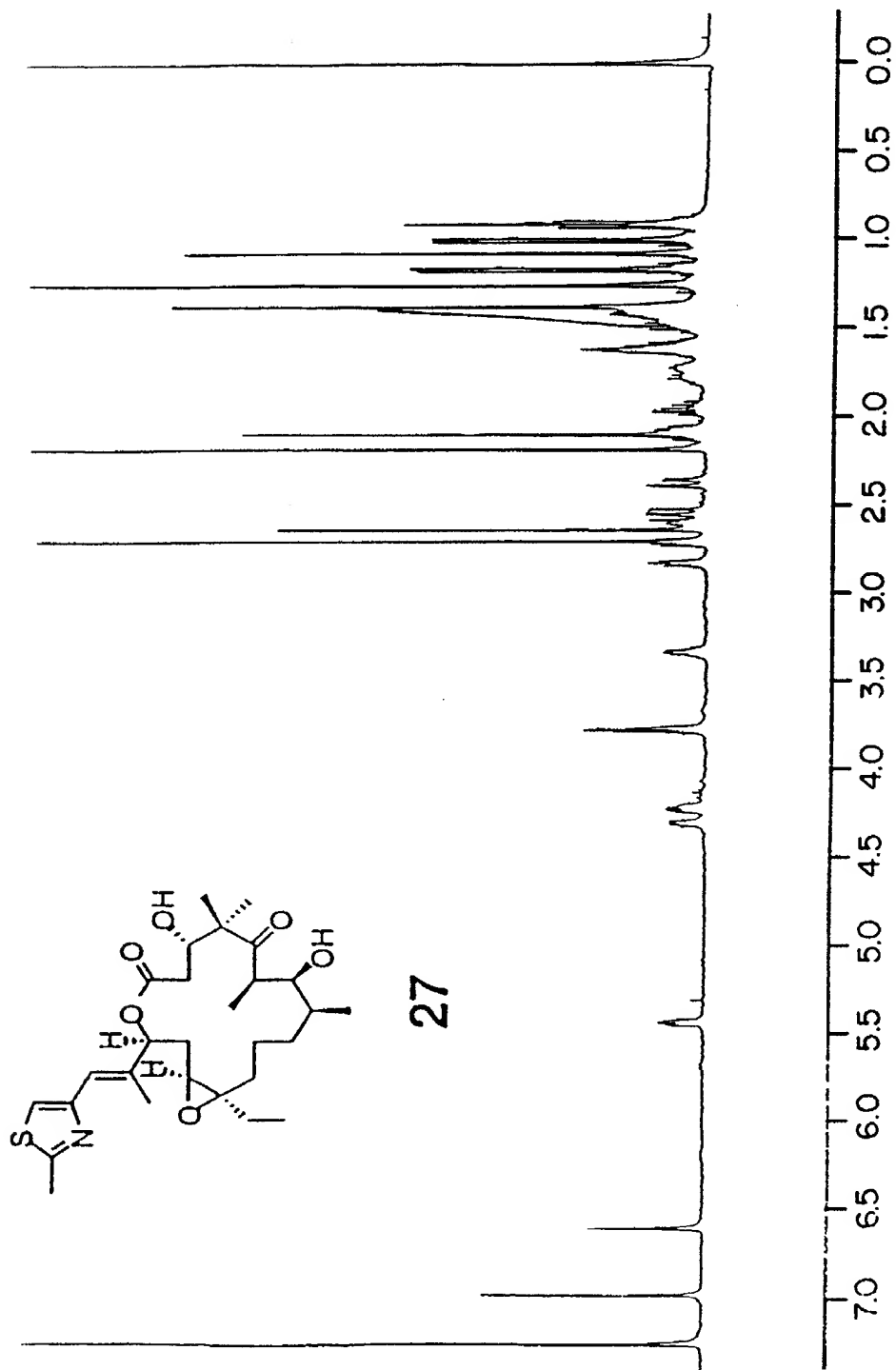
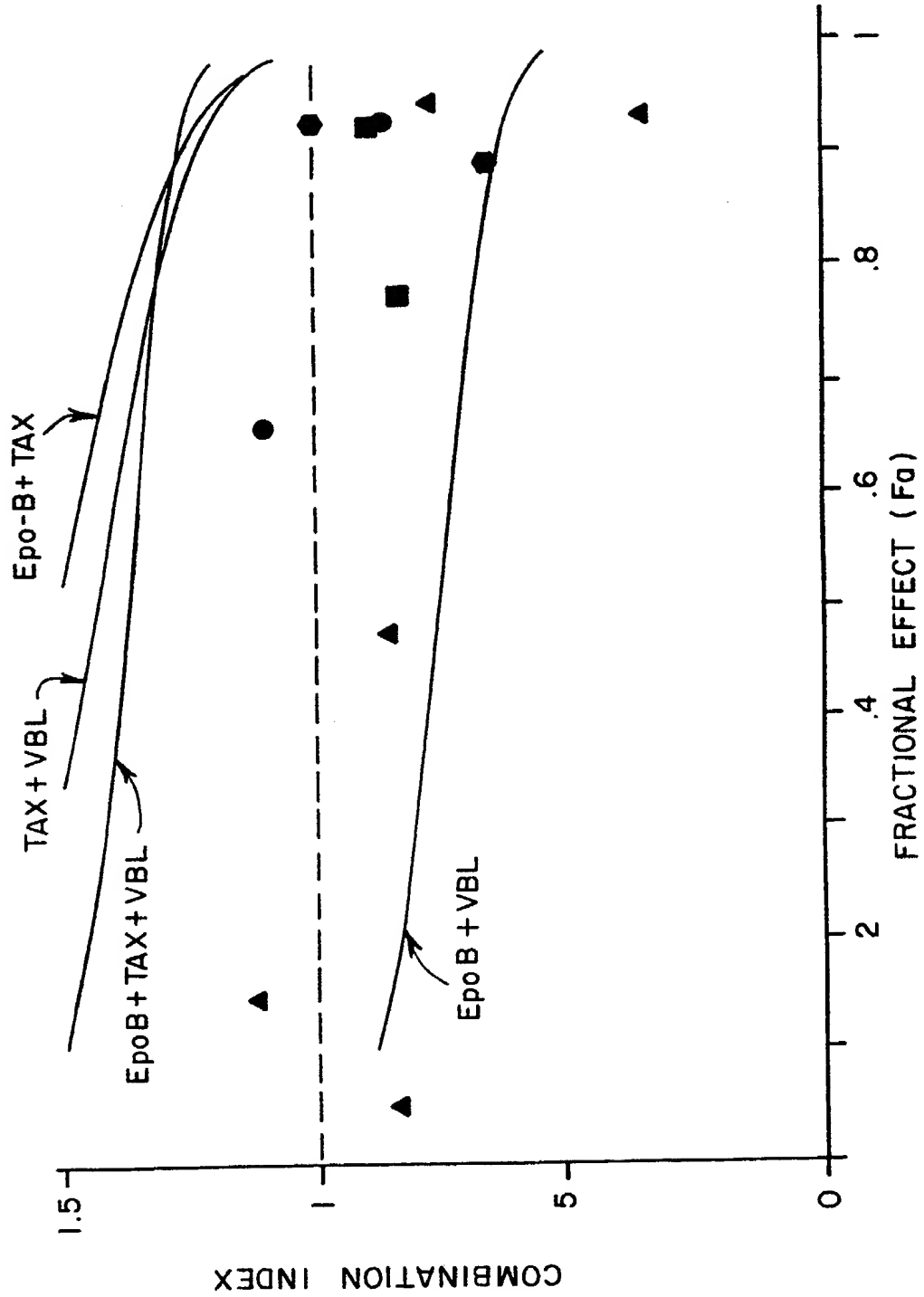
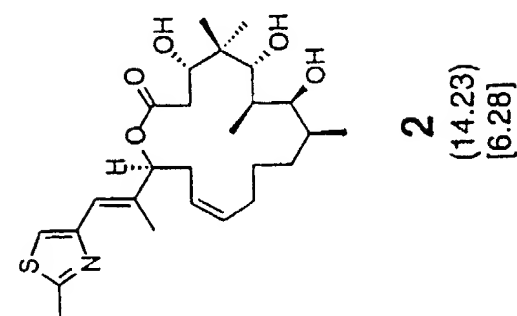
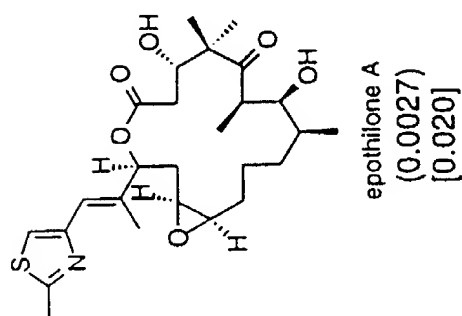
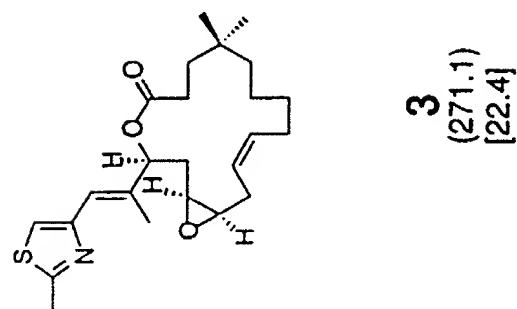
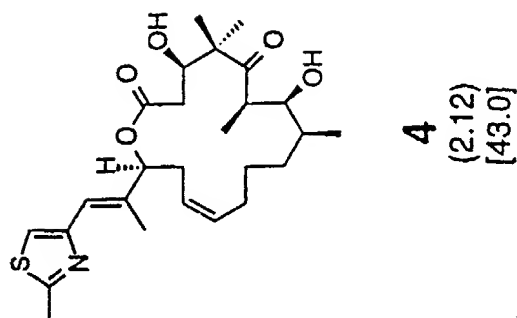
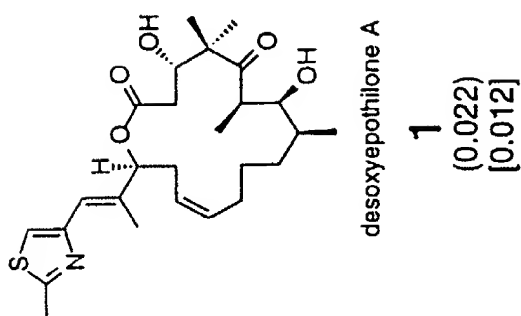


FIG. 38



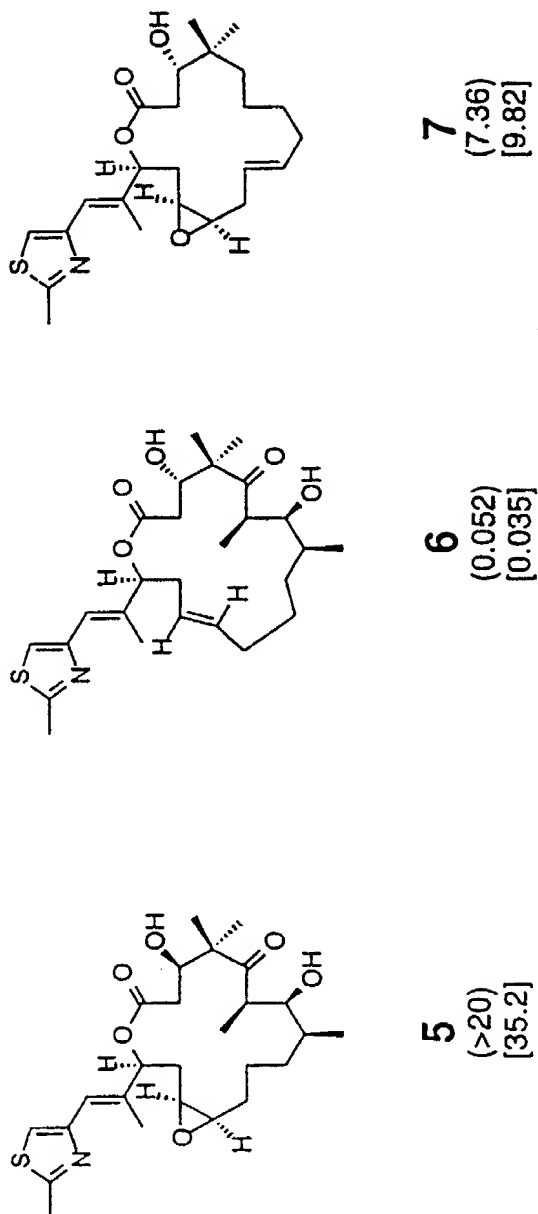
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FIG. 39A



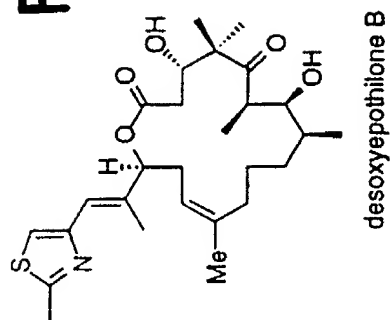
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FIG. 39B

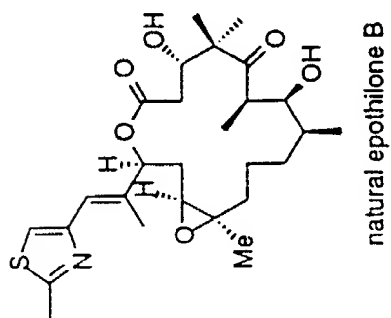
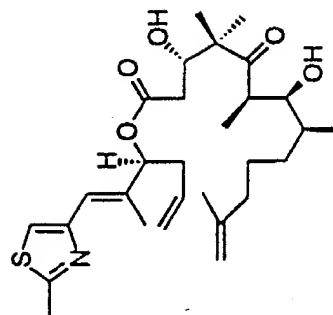


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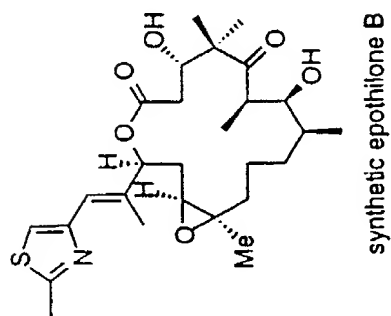
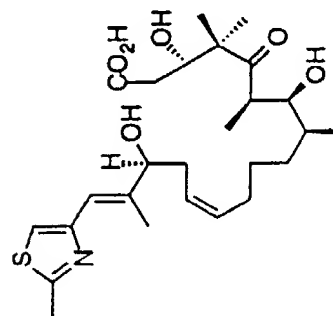
FIG. 40A



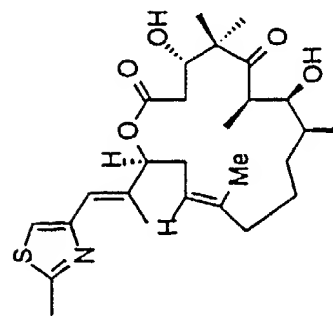
10
(0.0095)
[0.017]



9
(0.00017)
[0.0012]

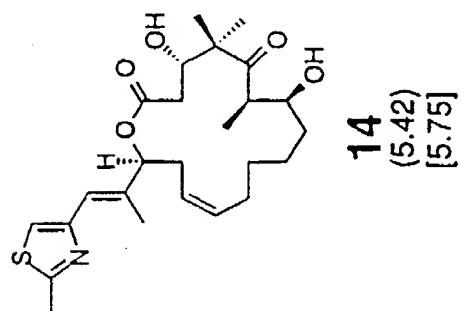
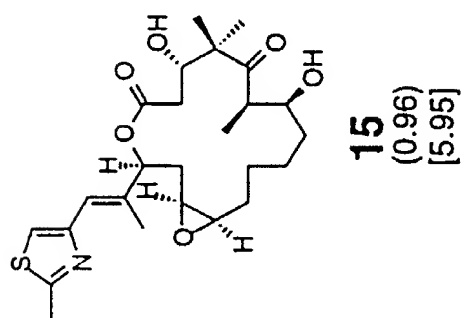
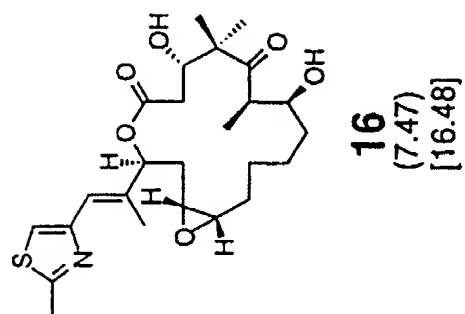


8
(0.00044)
[0.0026]



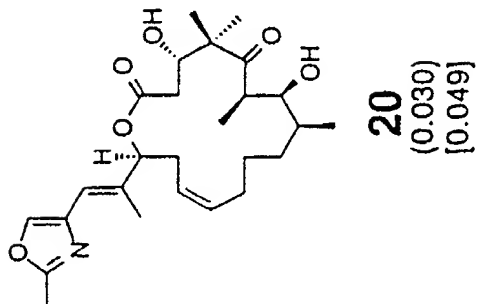
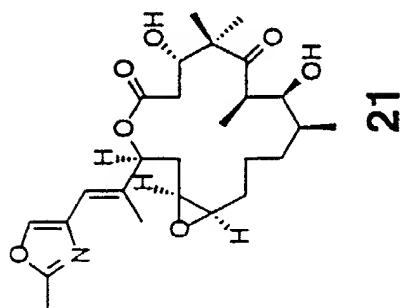
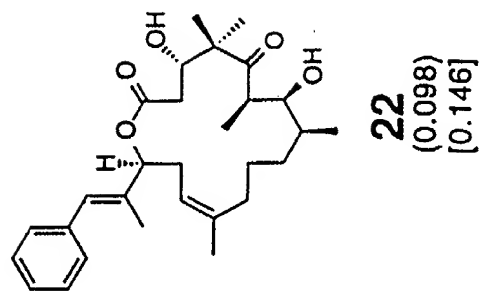
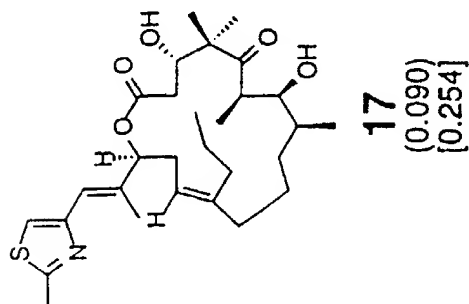
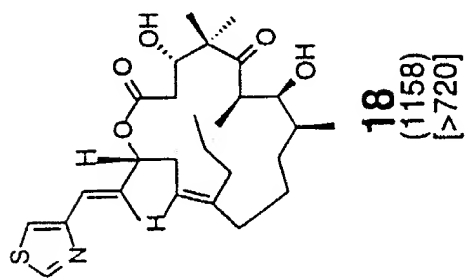
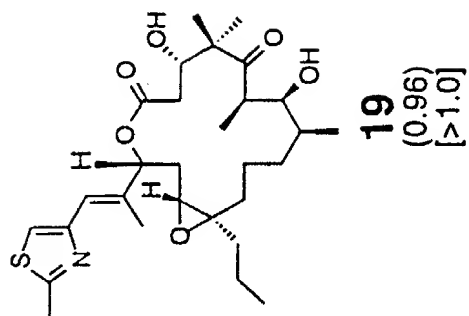
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FIG. 40B



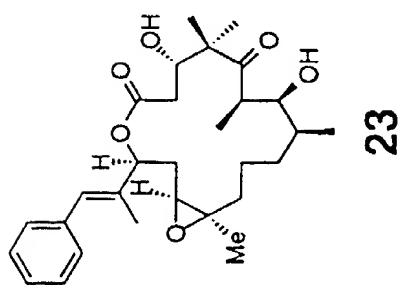
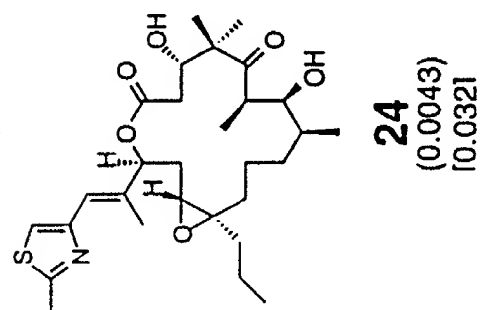
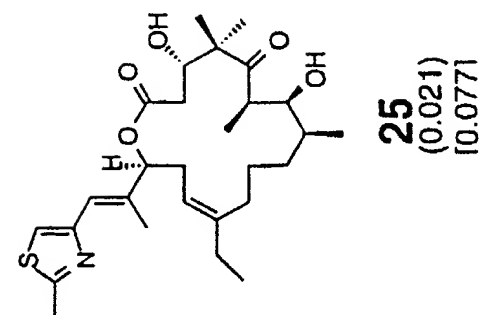
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FIG. 41A



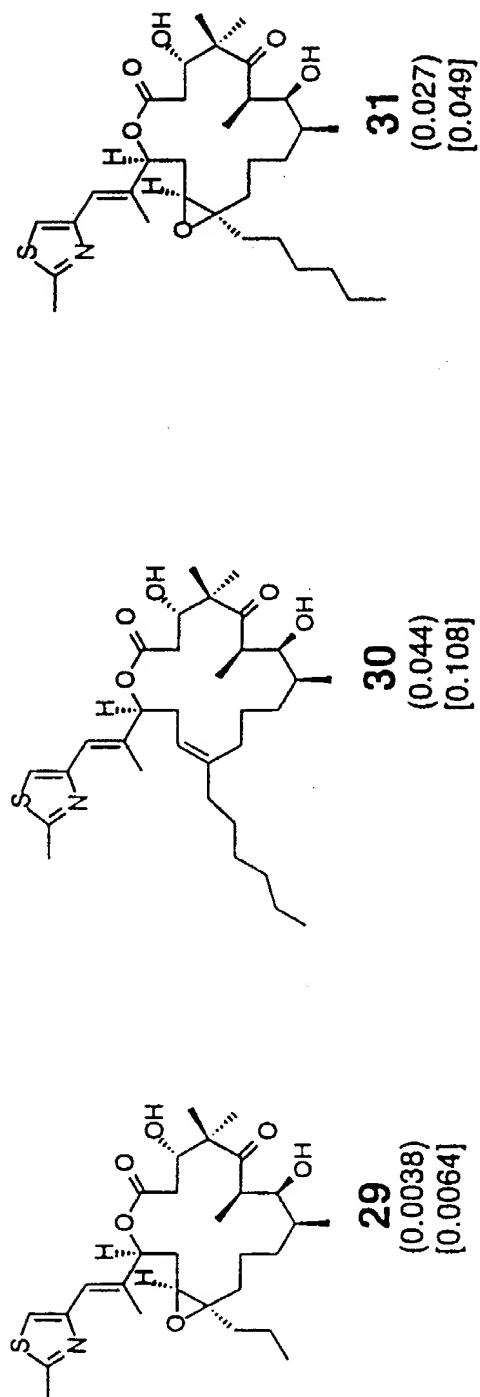
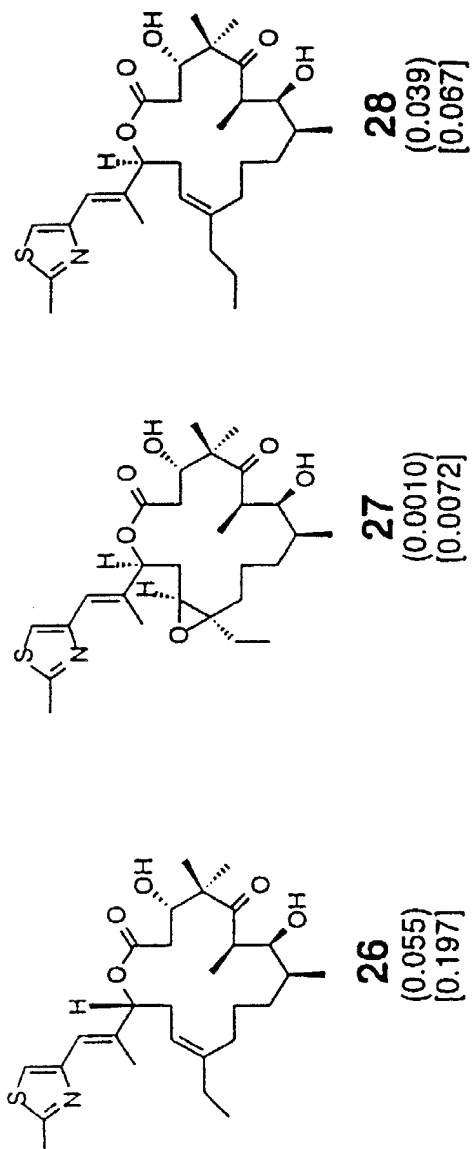
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FIG. 41B



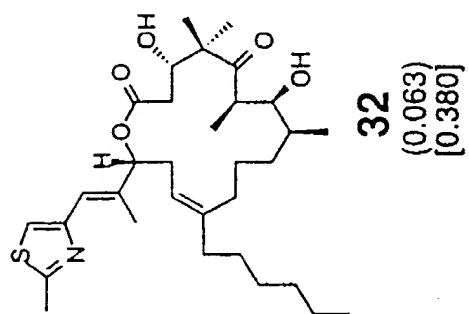
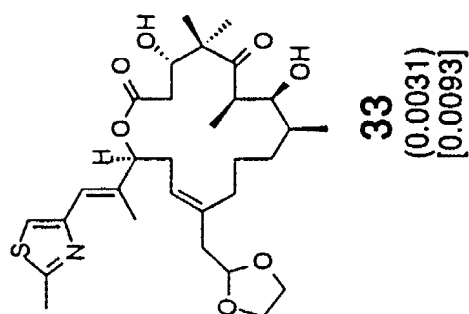
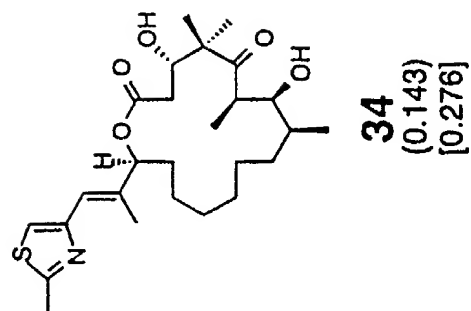
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FIG. 42A



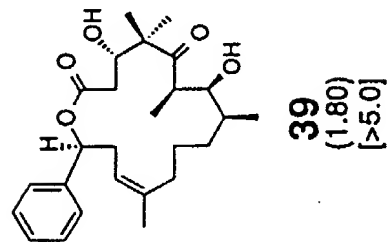
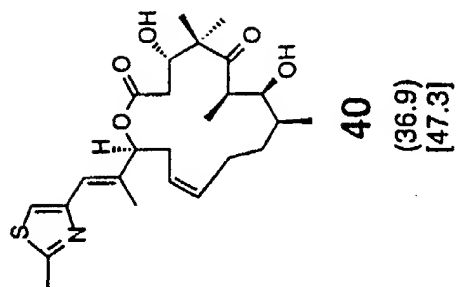
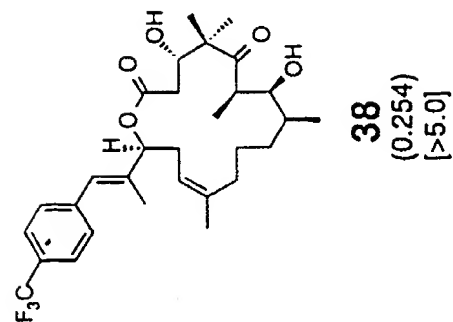
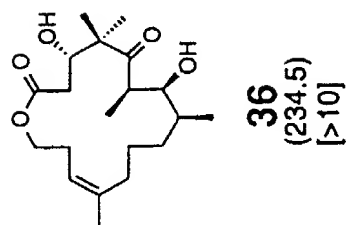
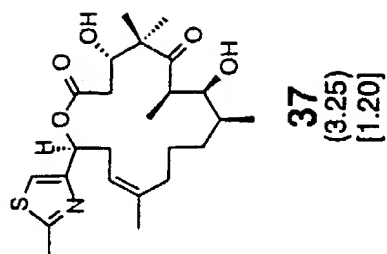
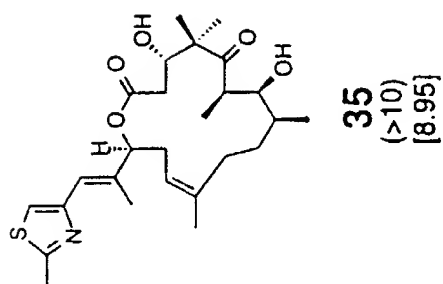
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FIG. 42B



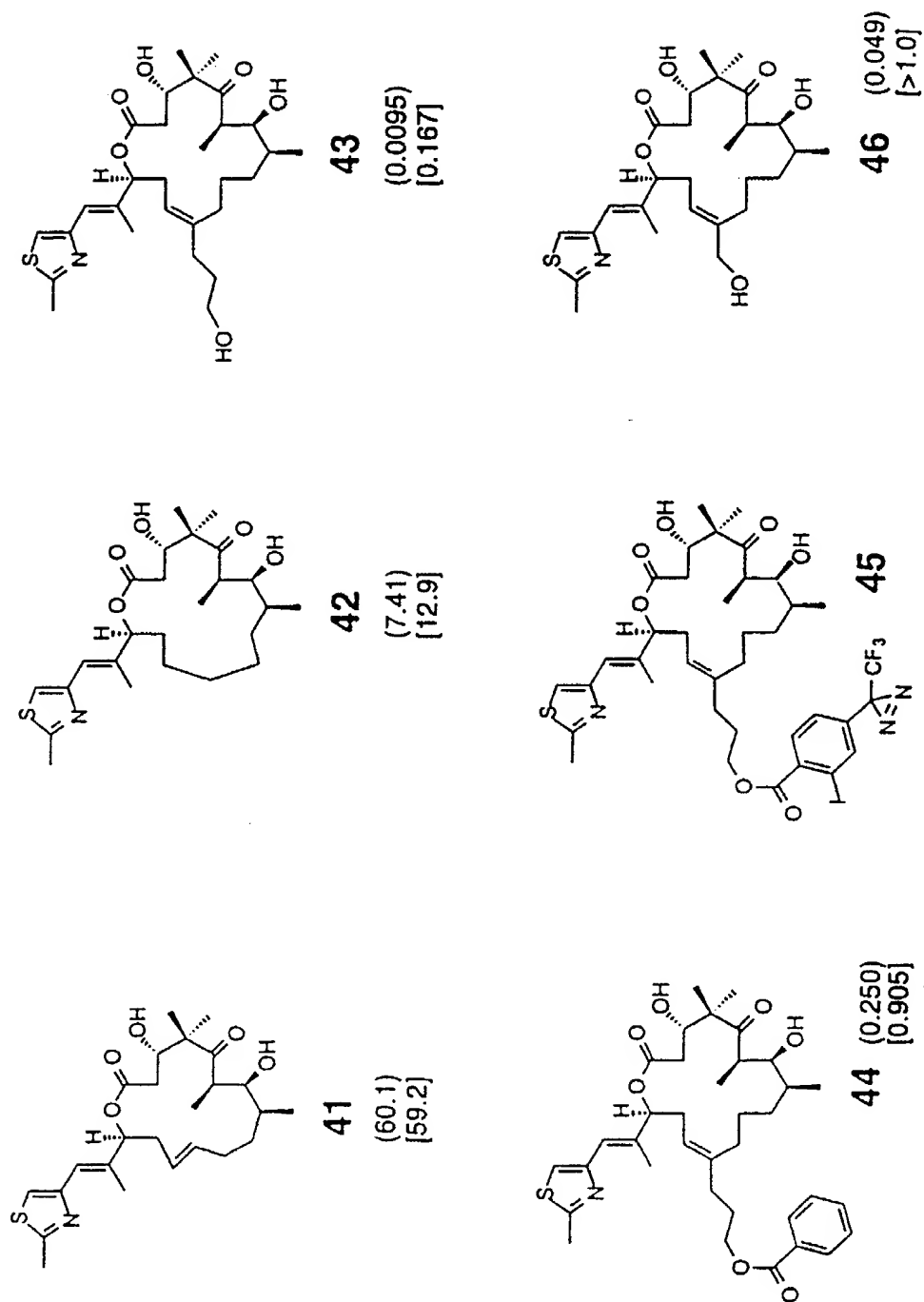
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FIG. 42C



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FIG. 42D



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FIG. 42E

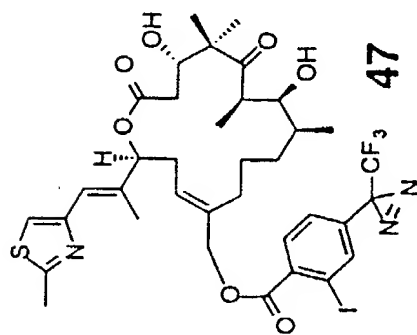
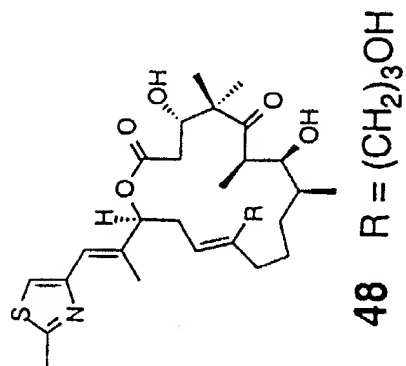
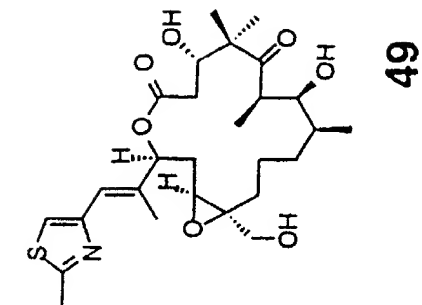
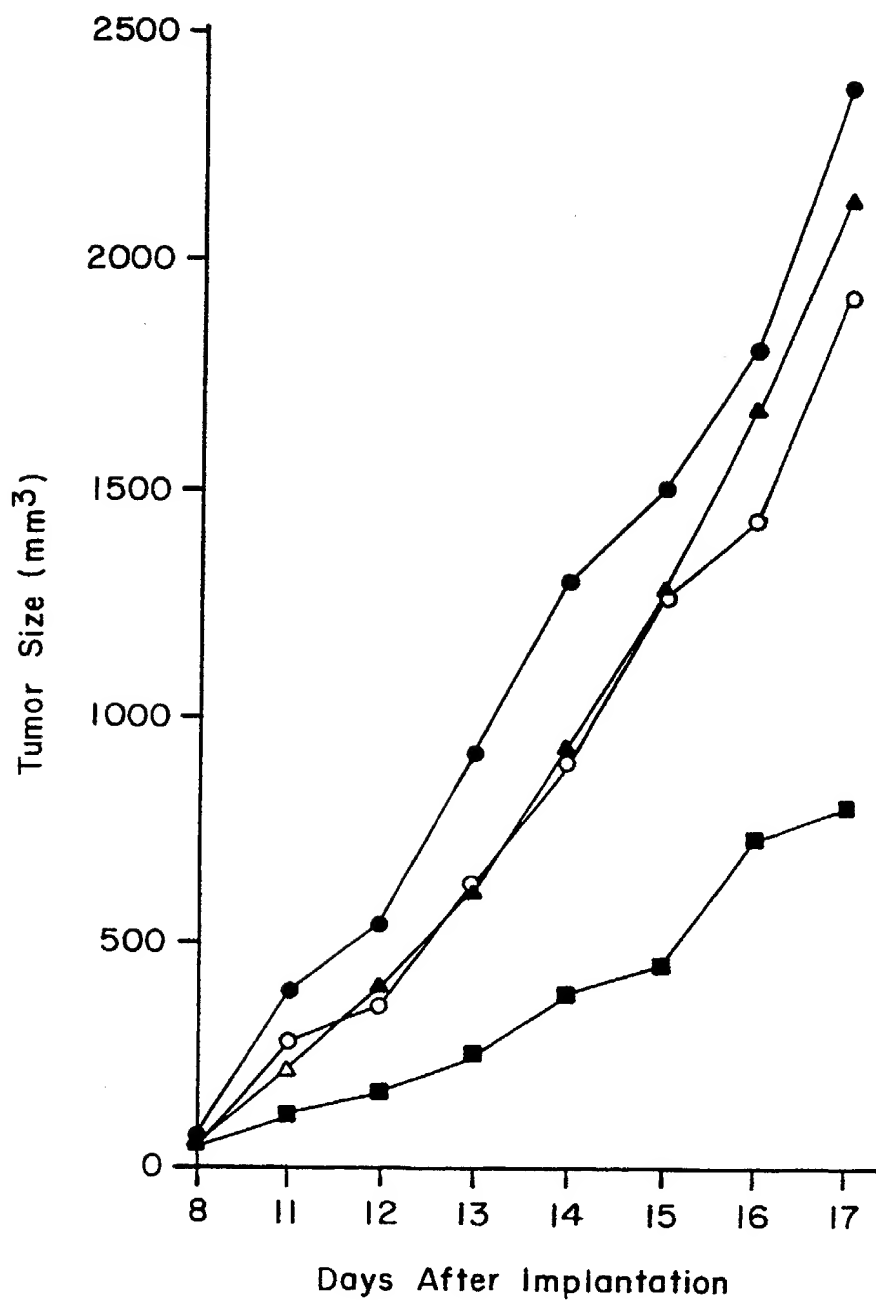
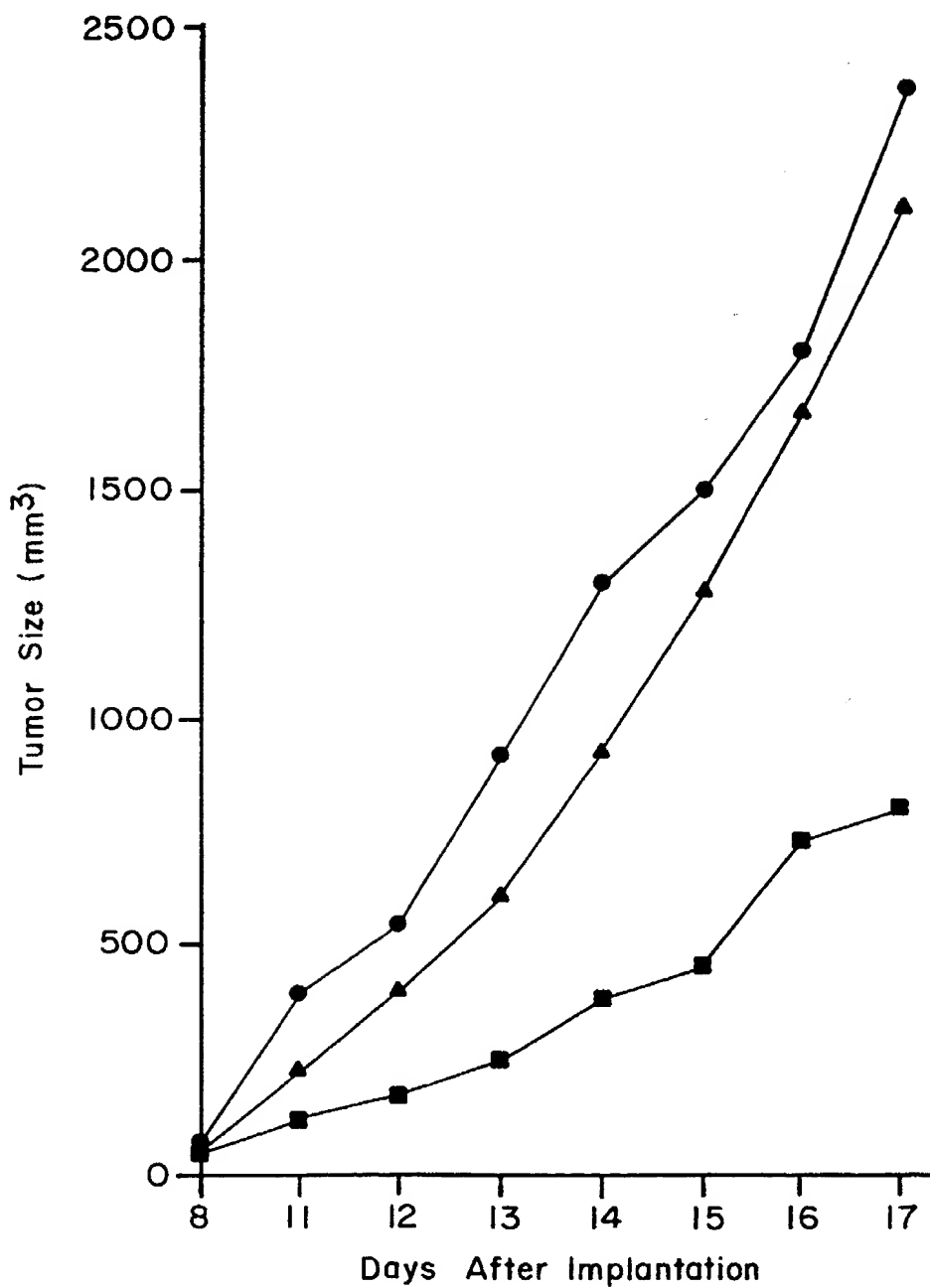


FIG. 43A



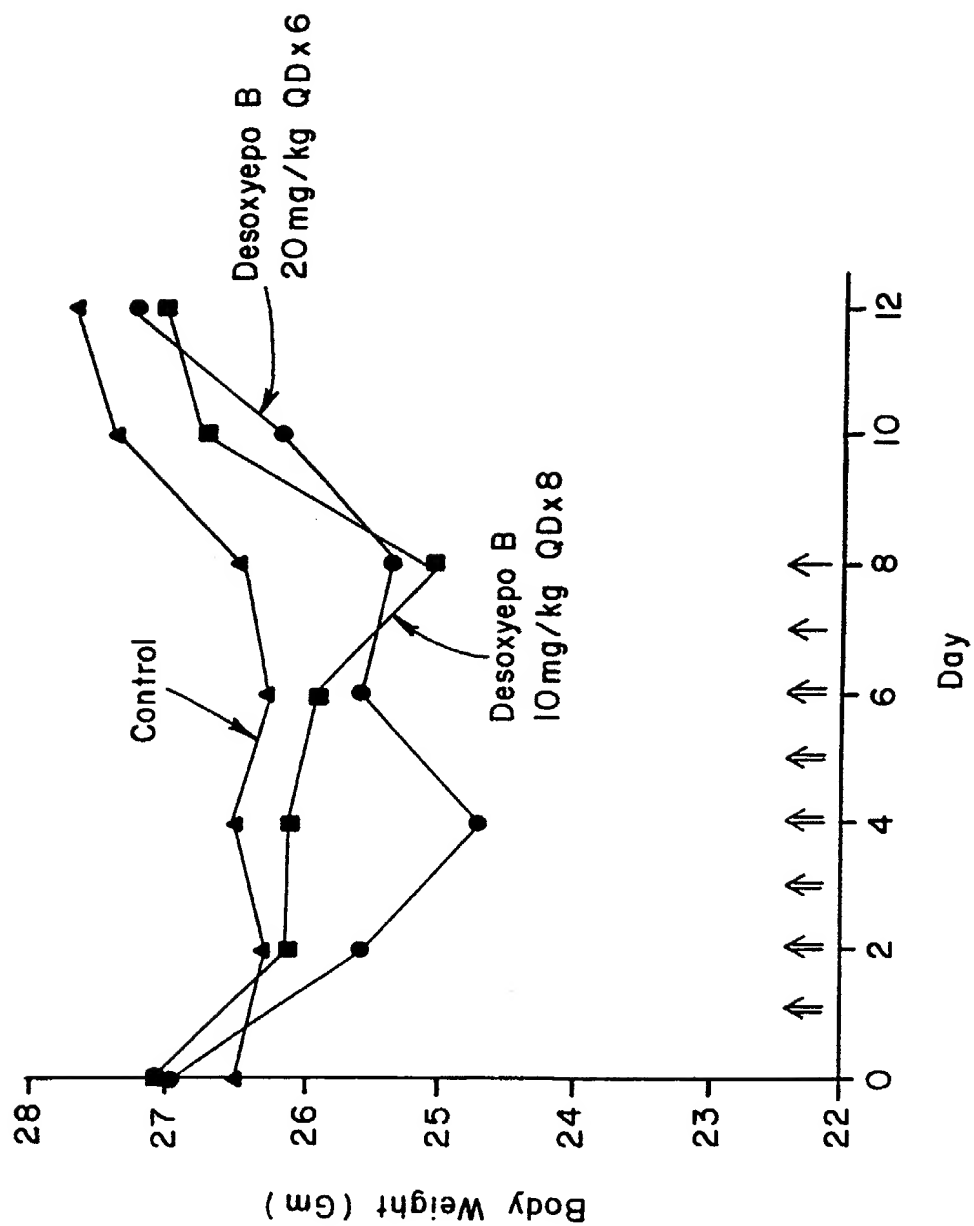
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FIG. 43B



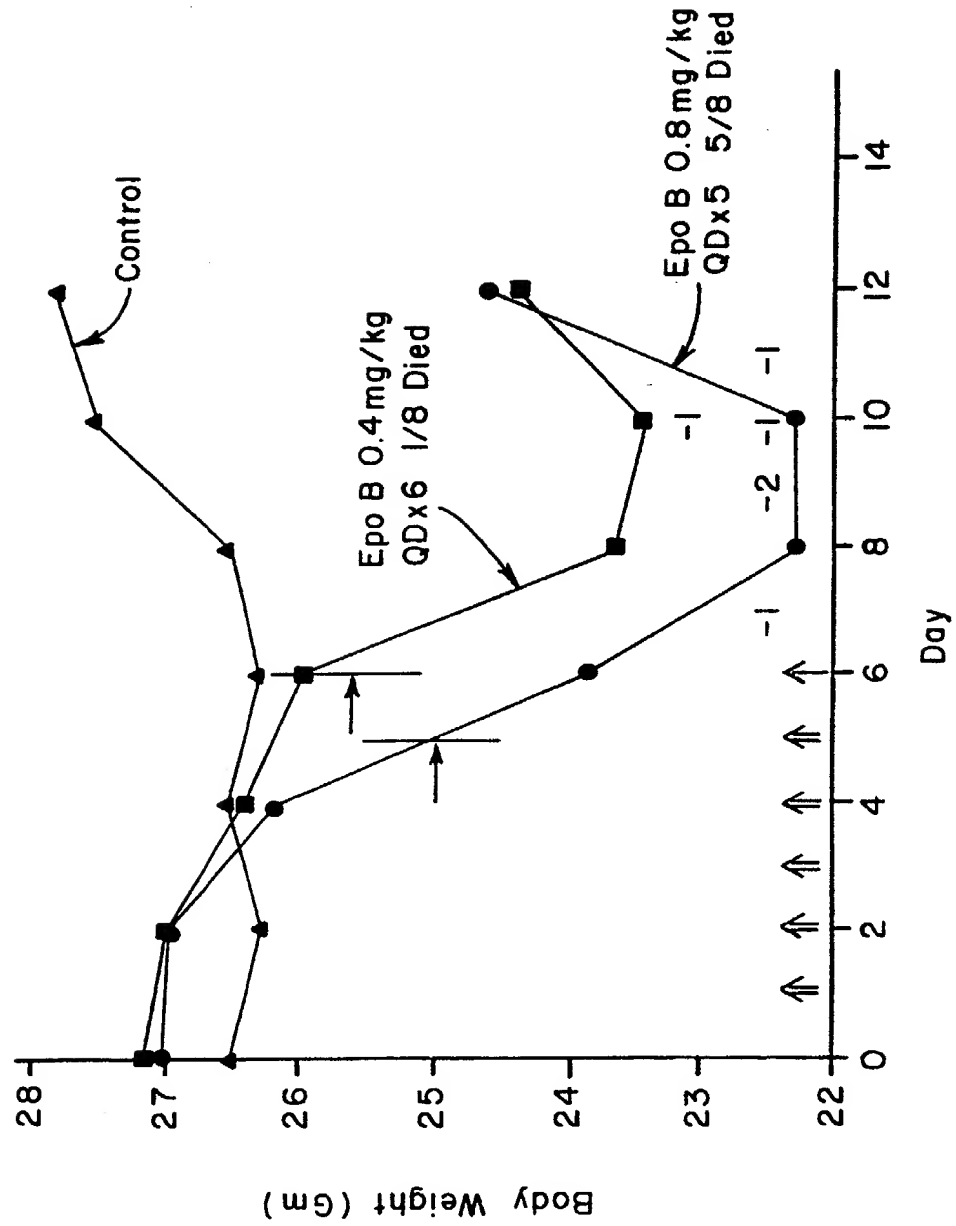
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FIG. 44A



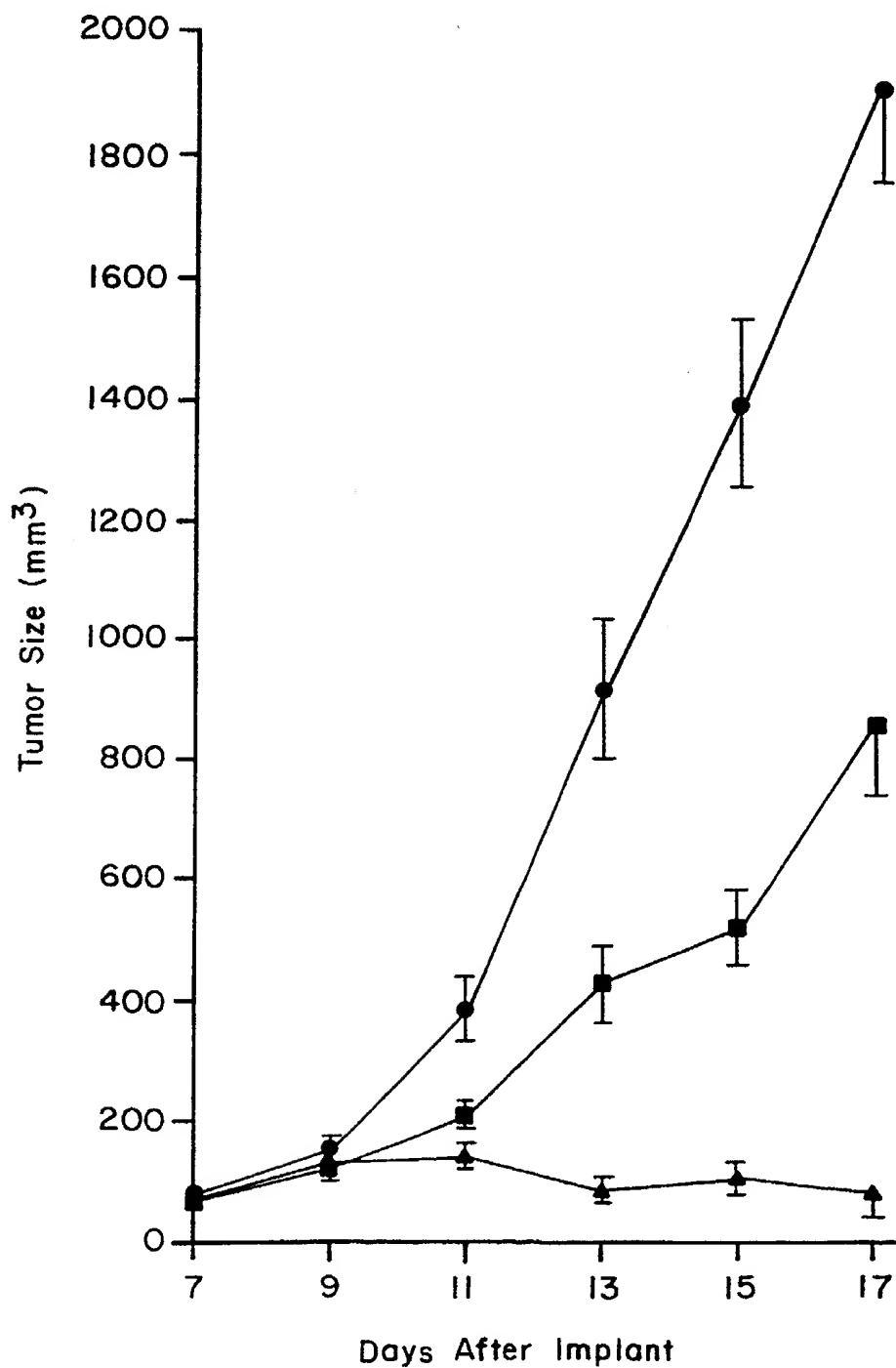
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FIG. 44B



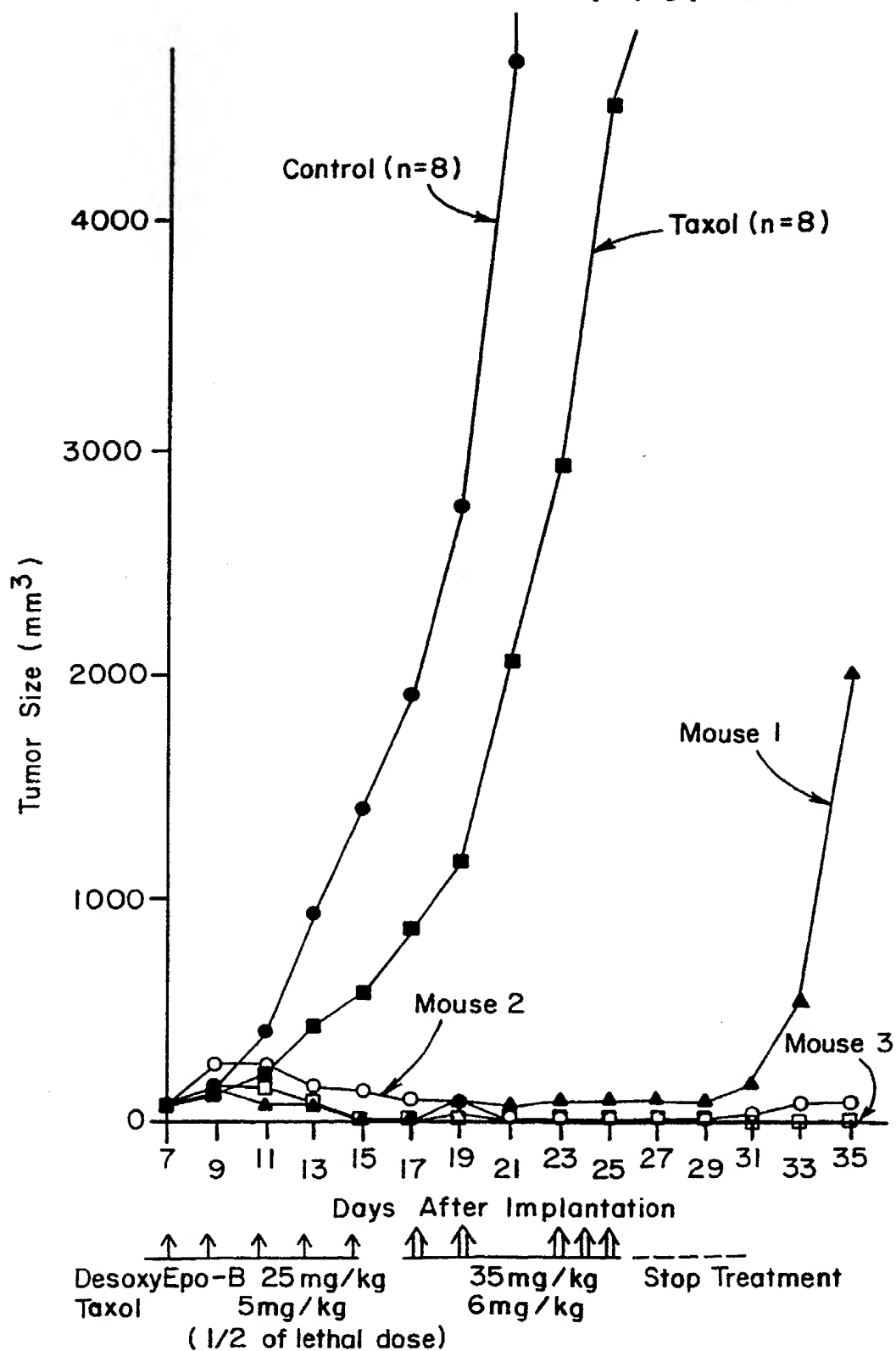
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FIG. 45A



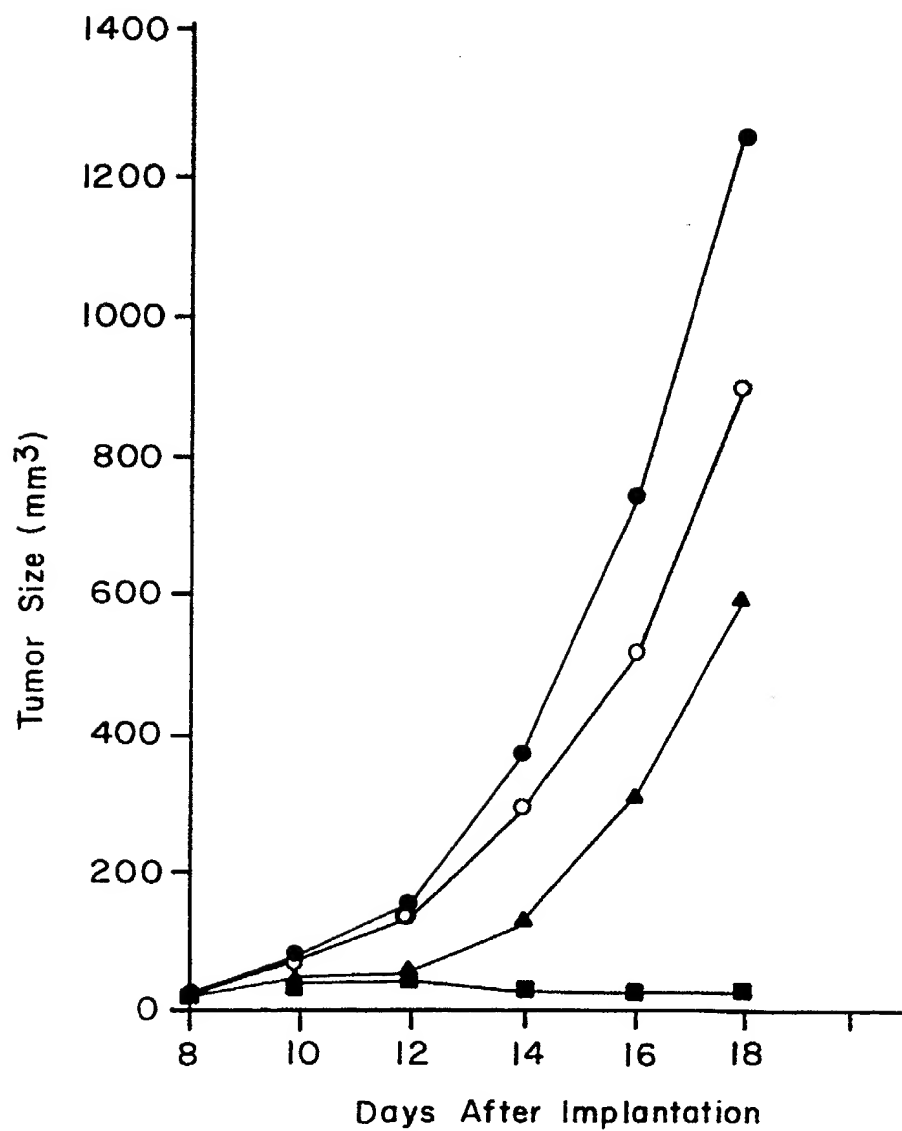
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FIG. 45 B



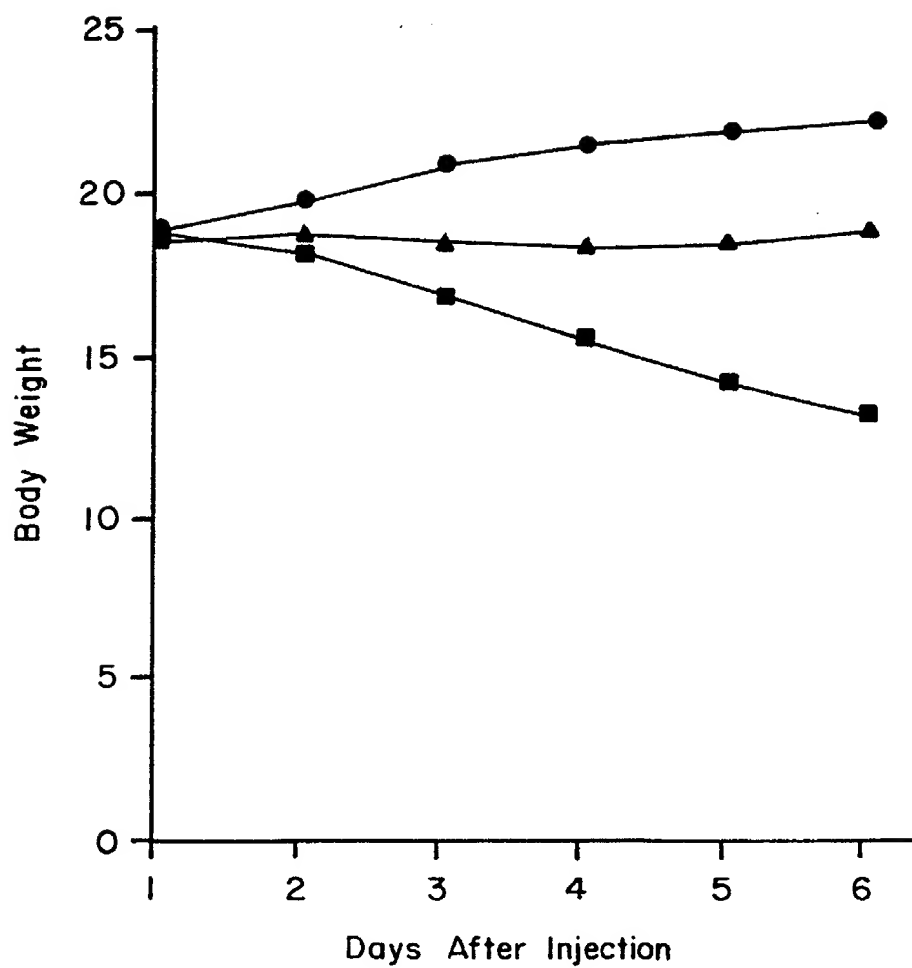
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FIG. 46



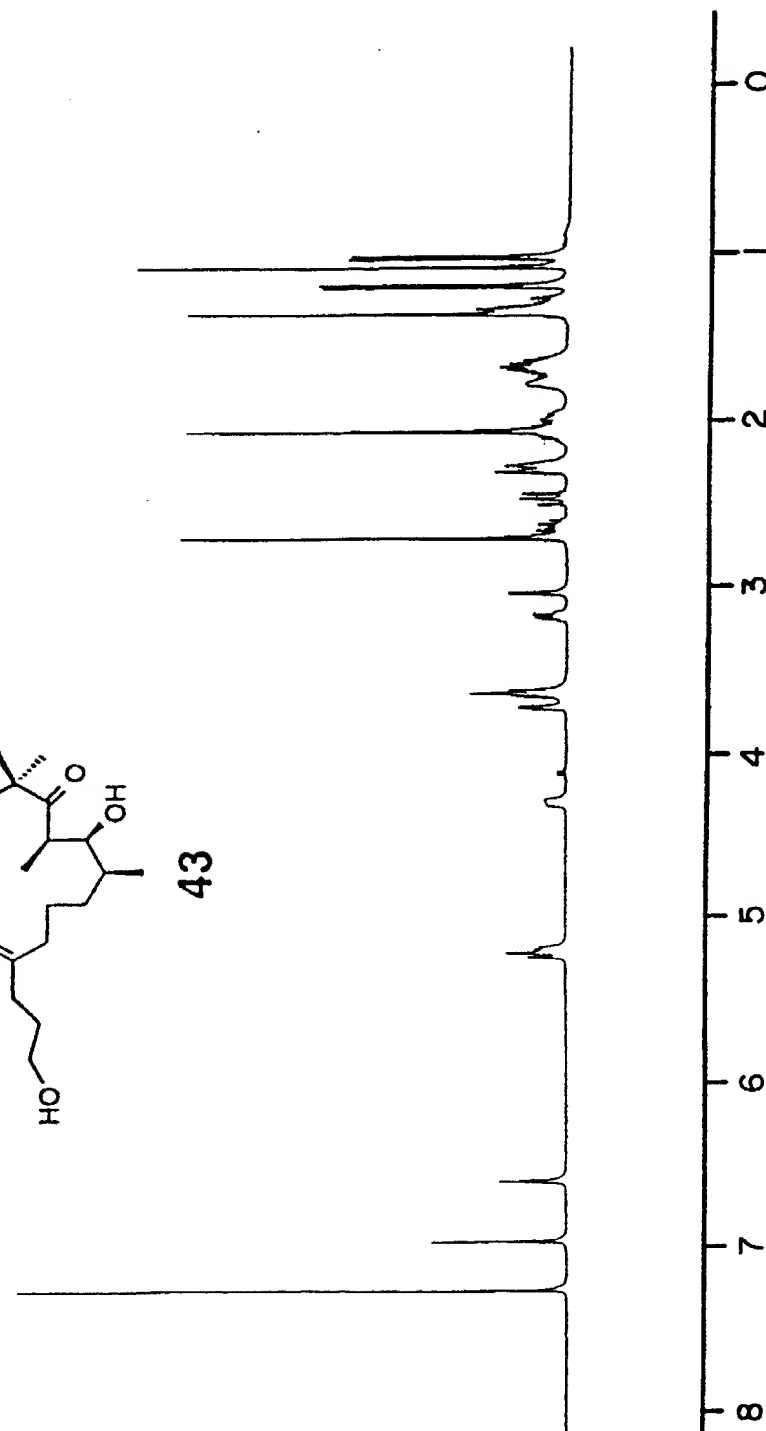
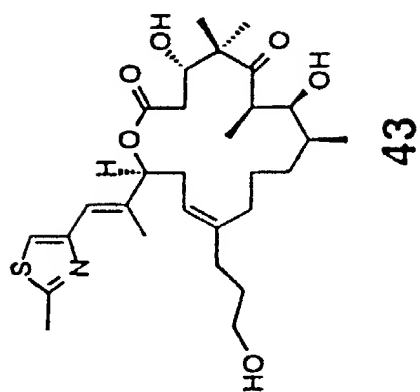
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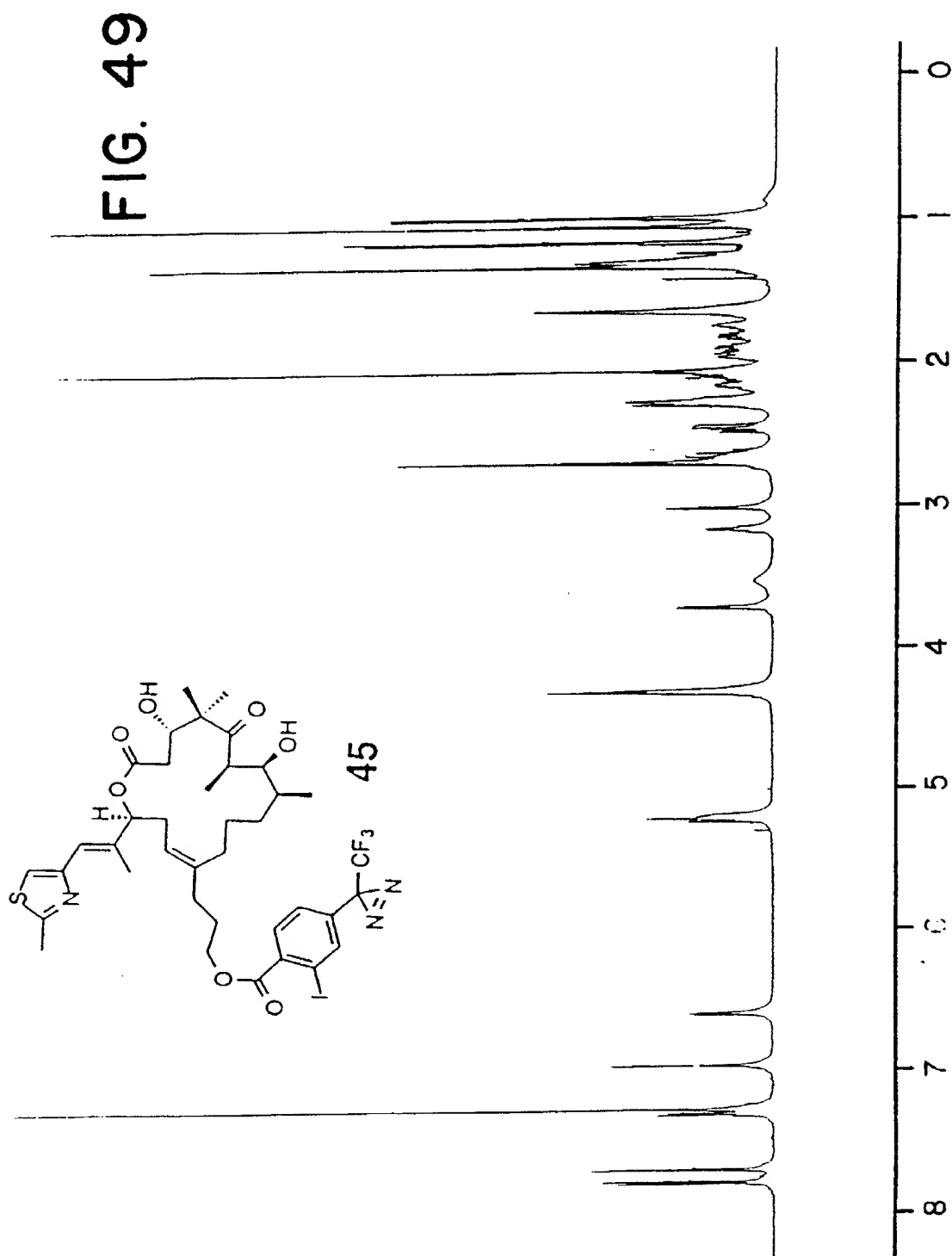
FIG. 47



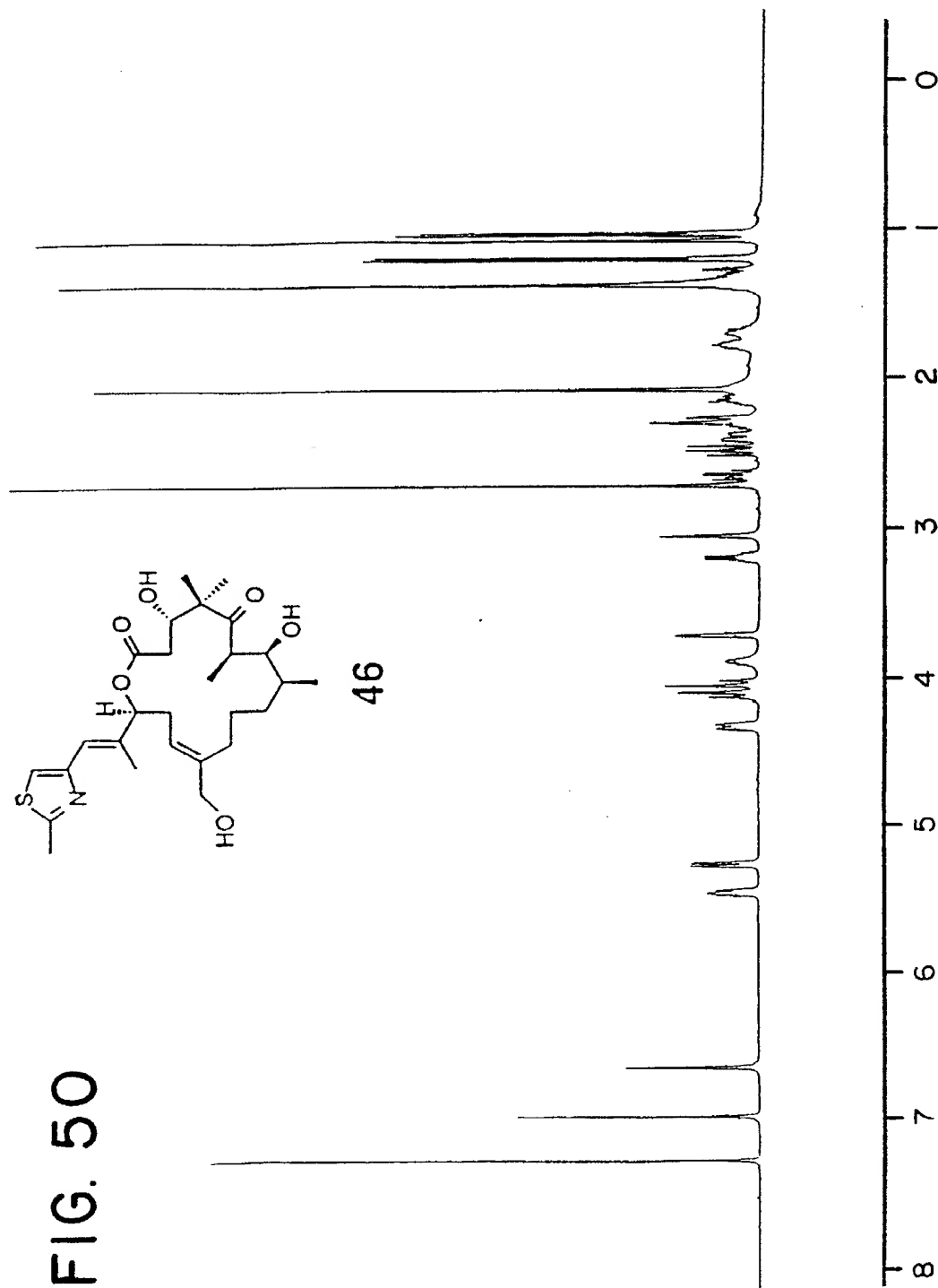
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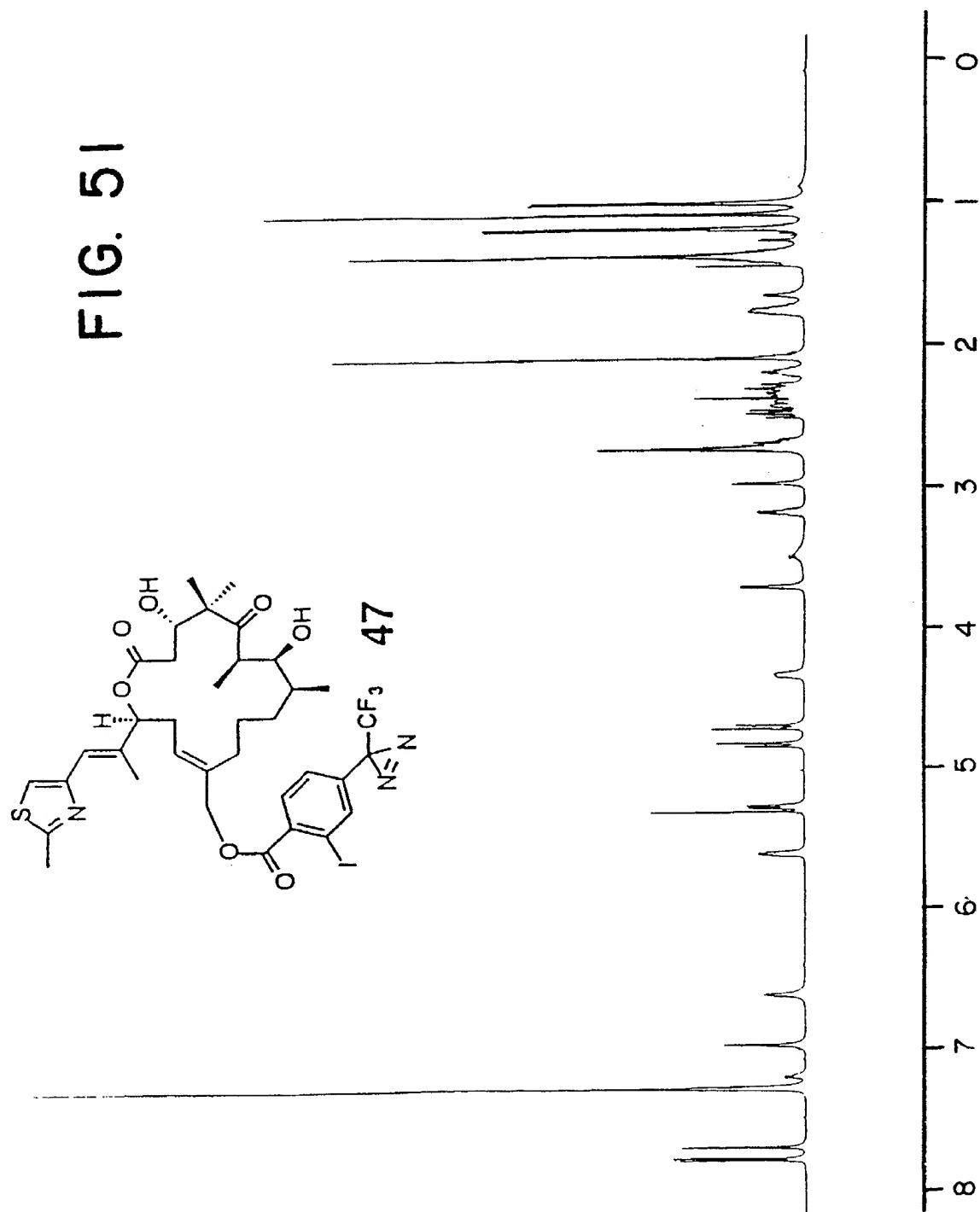
FIG. 48





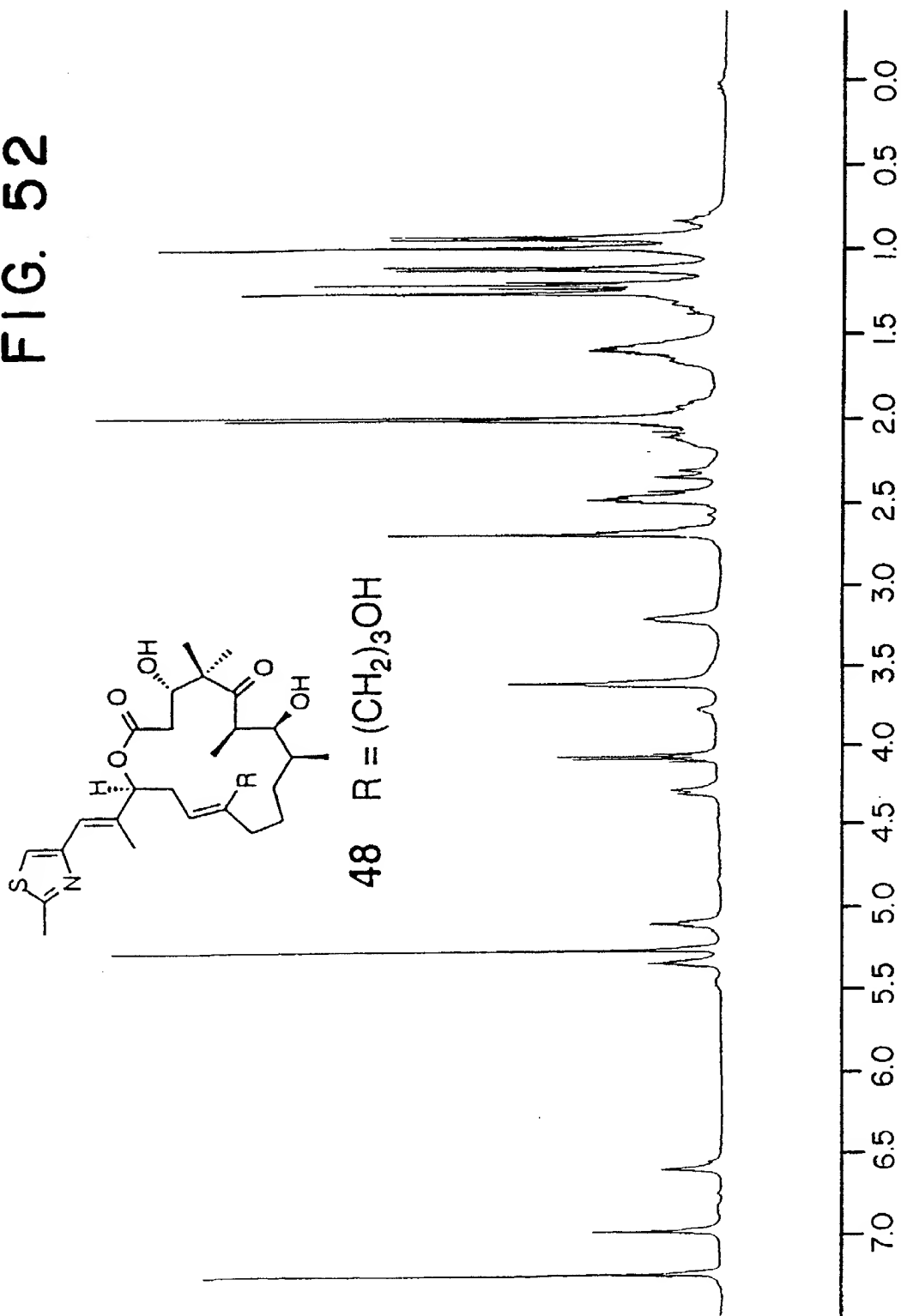
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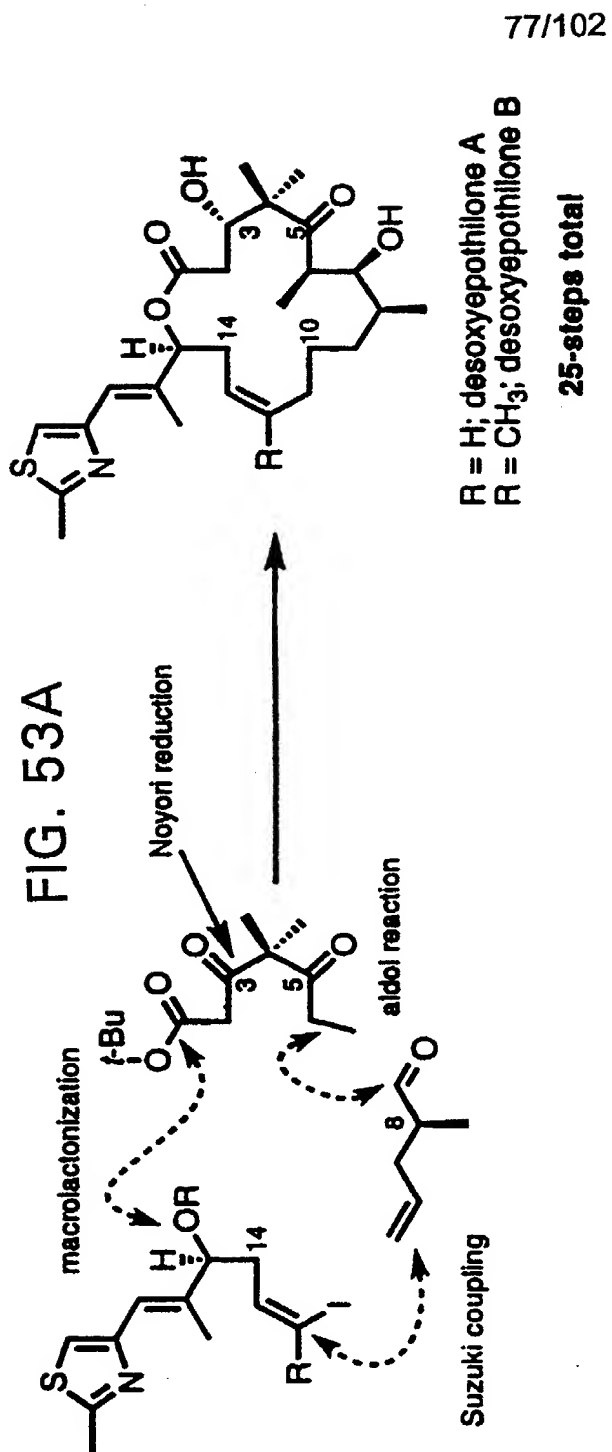




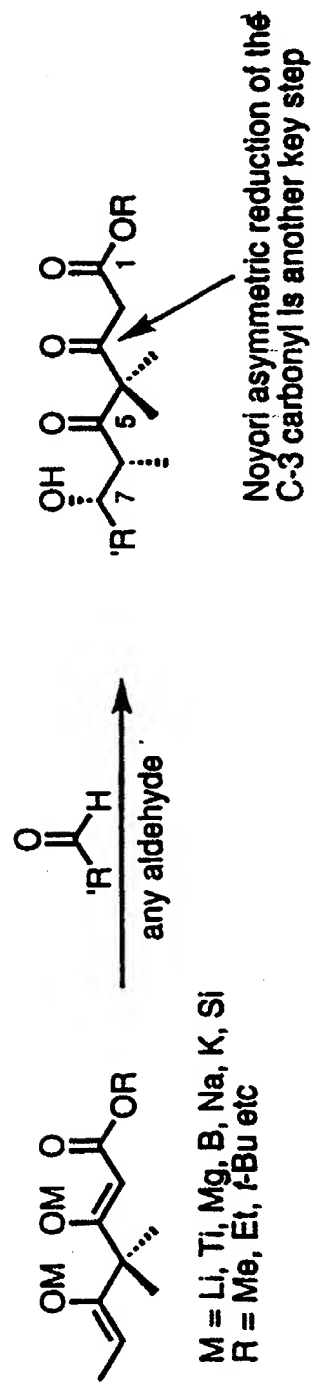
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FIG. 52



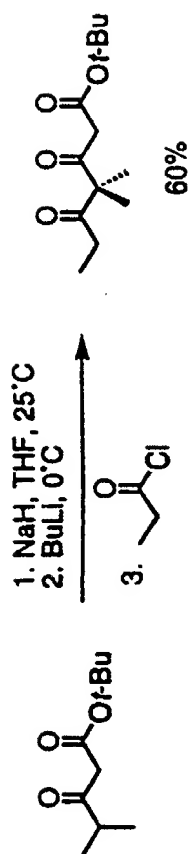


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FIG. 53B

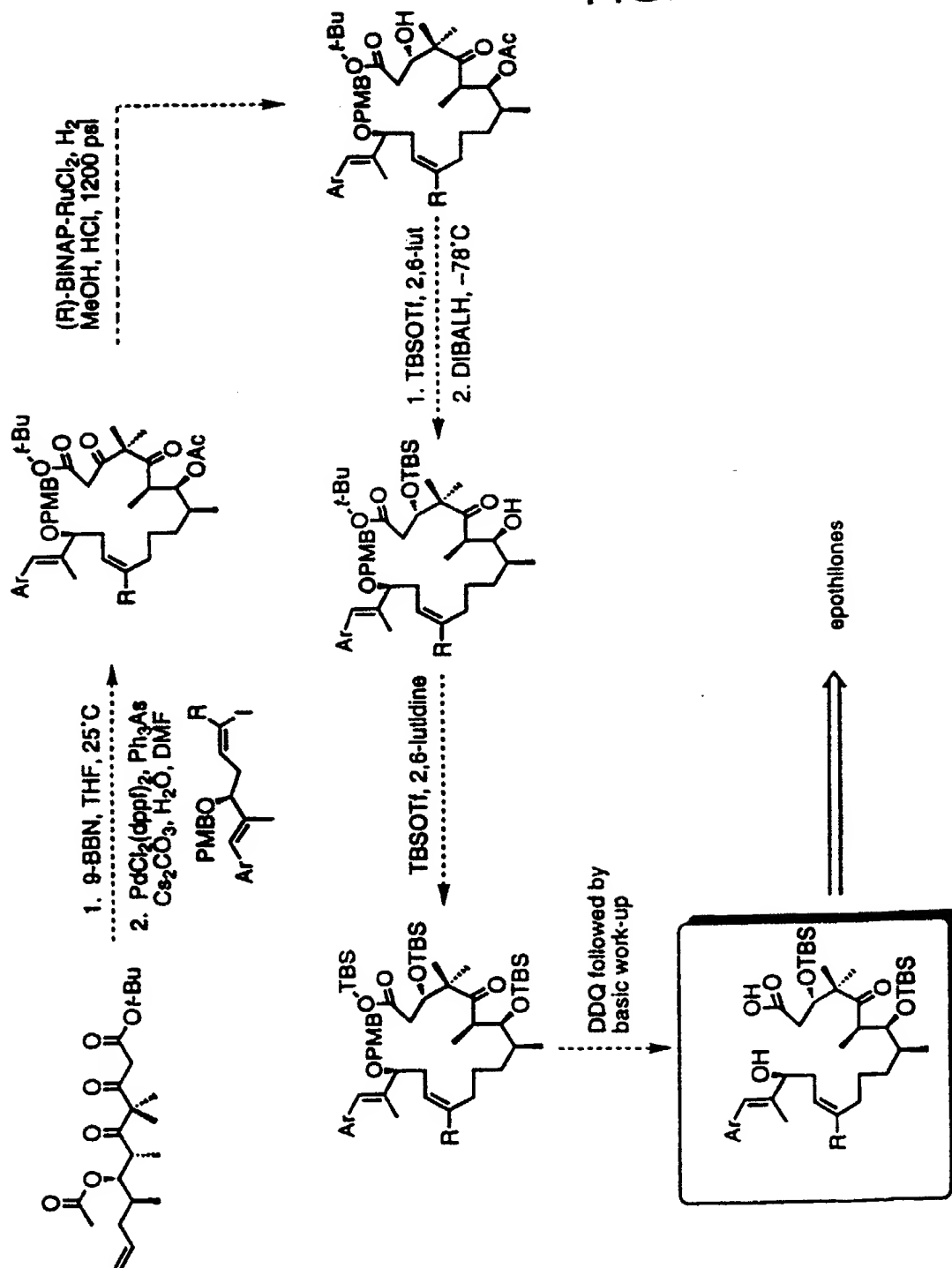
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FIG. 54



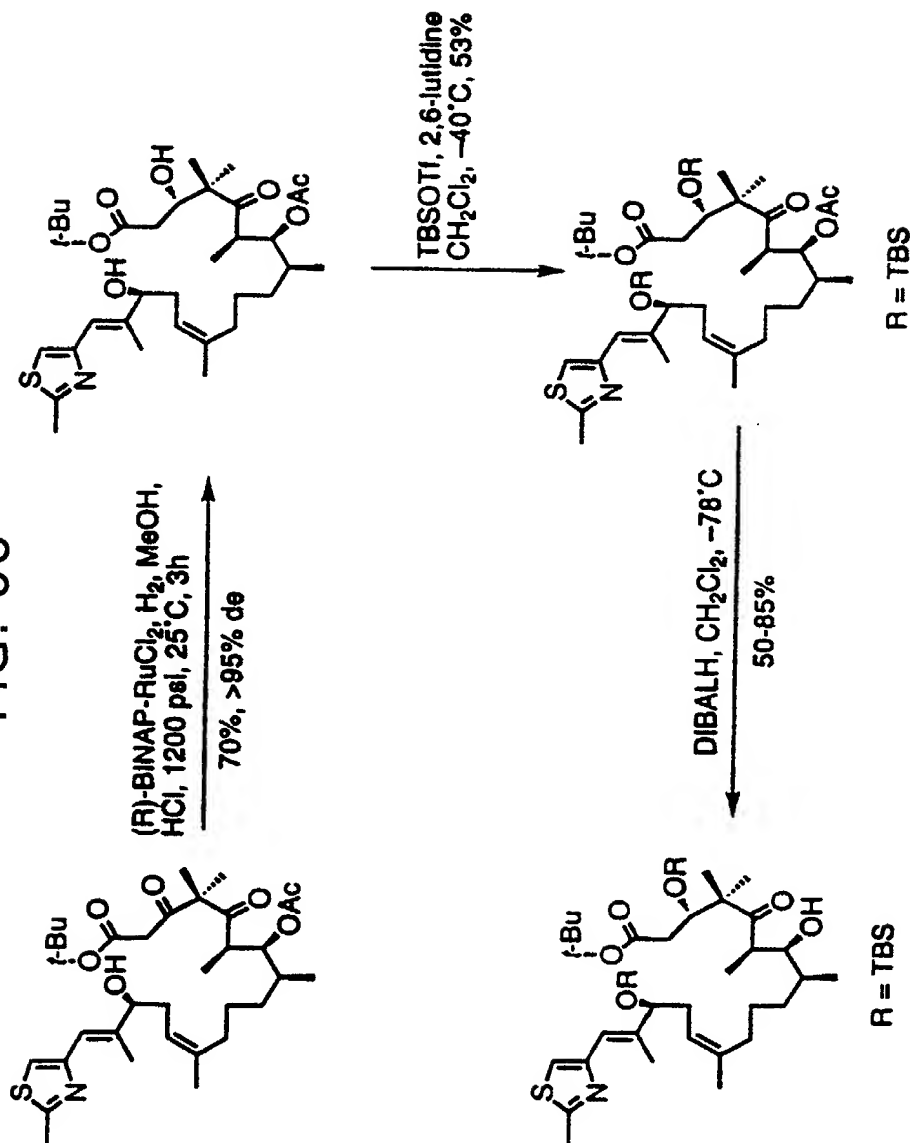
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FIG. 55



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FIG. 56



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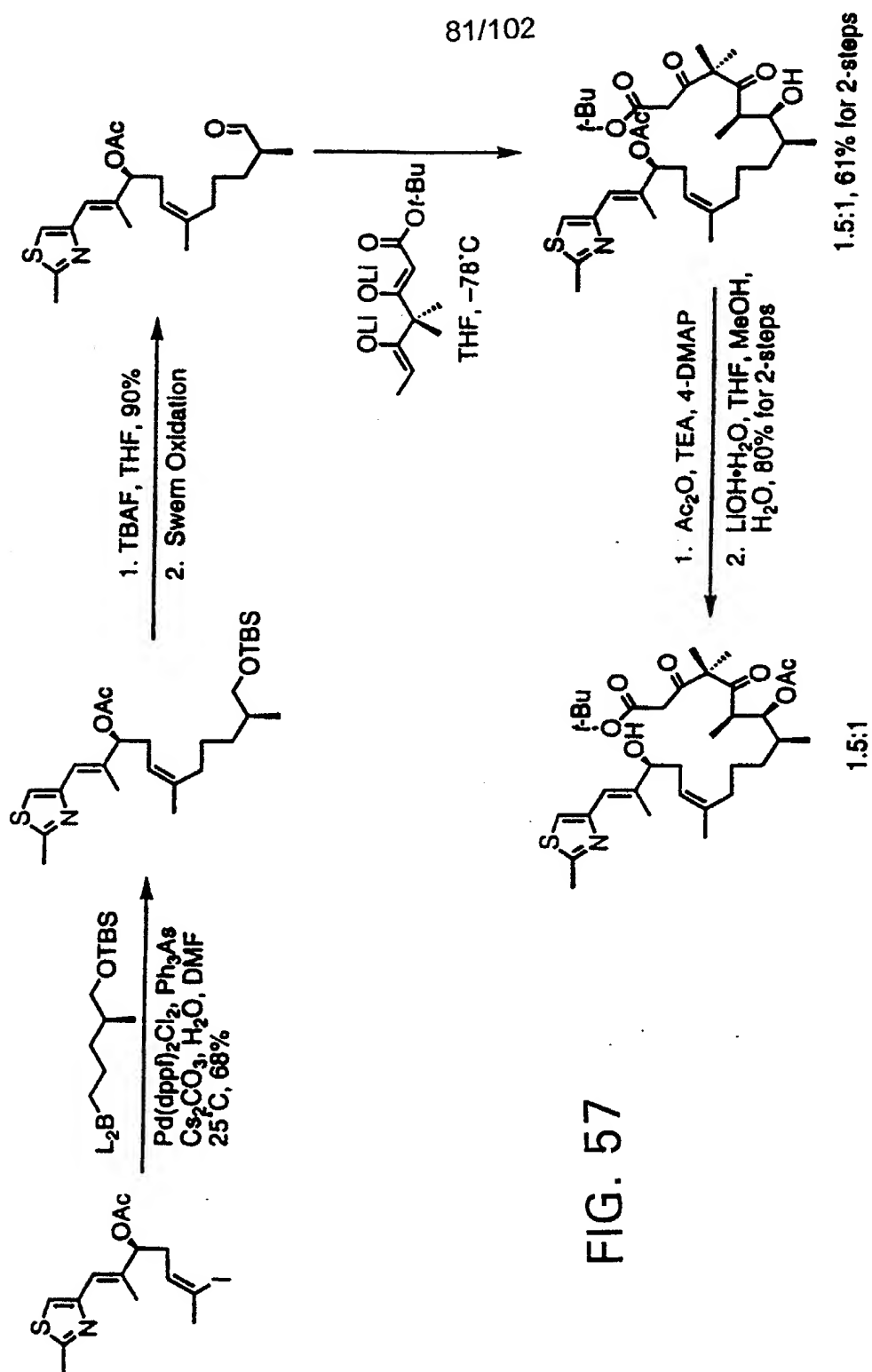
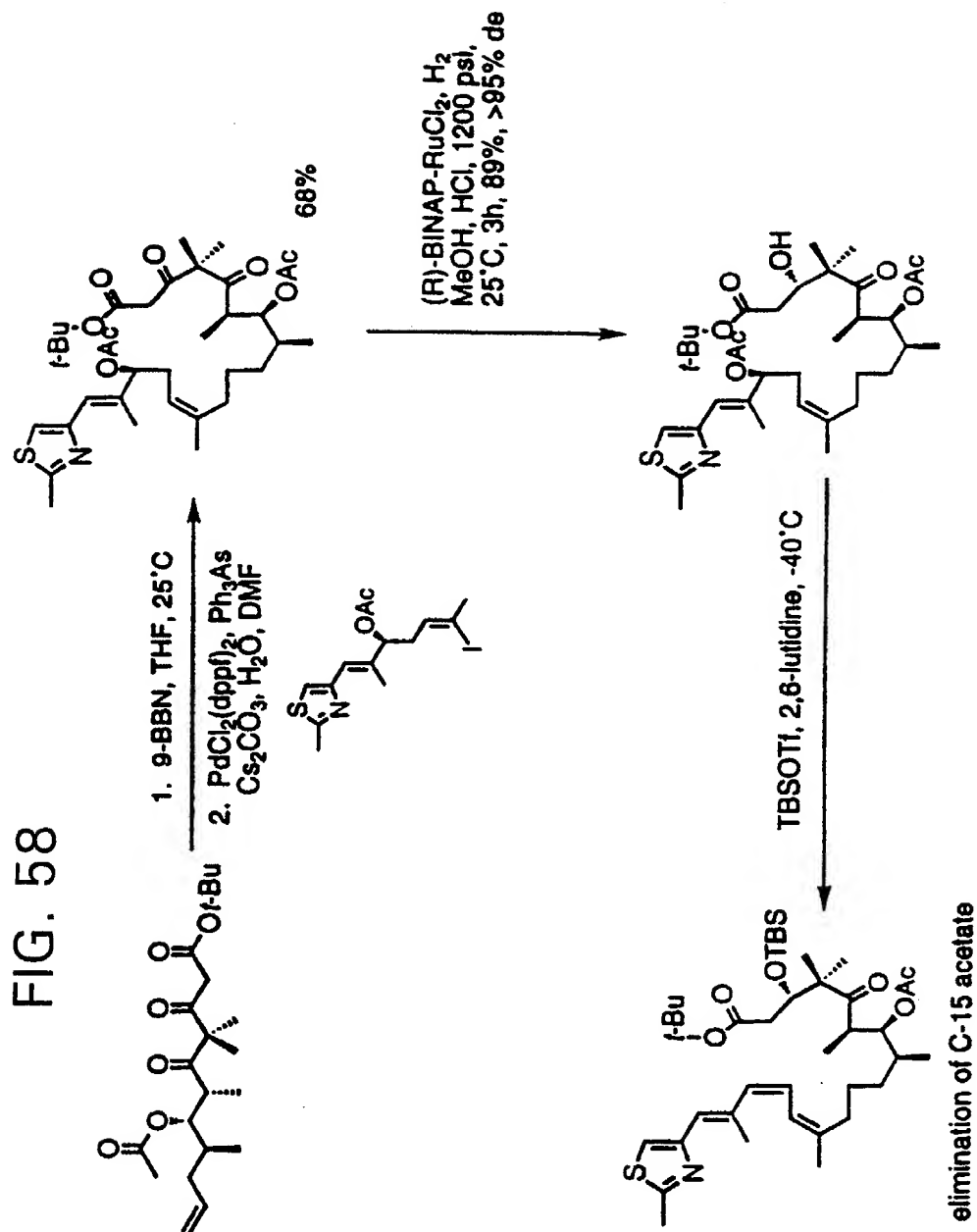


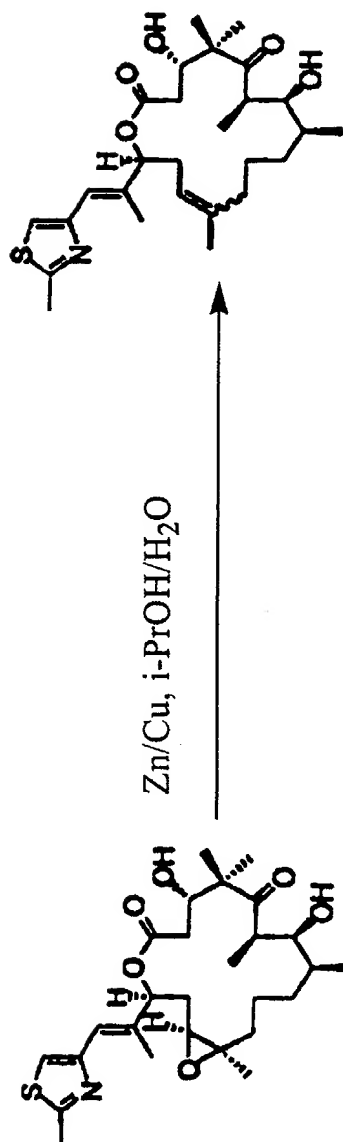
FIG. 57

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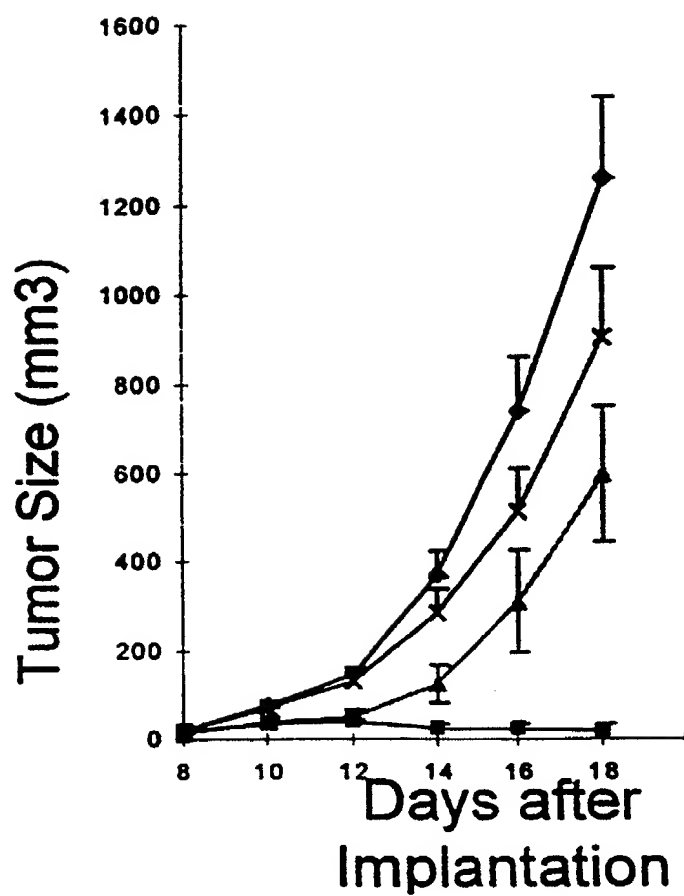
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FIG. 59



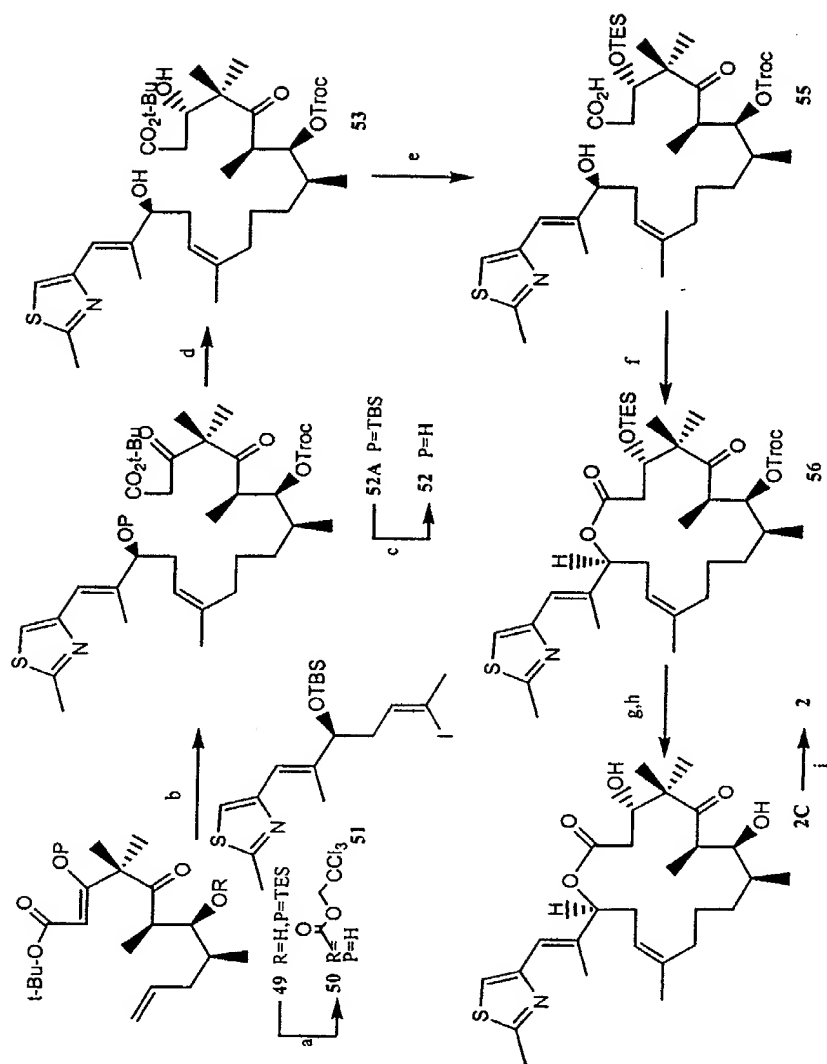
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FIG. 60



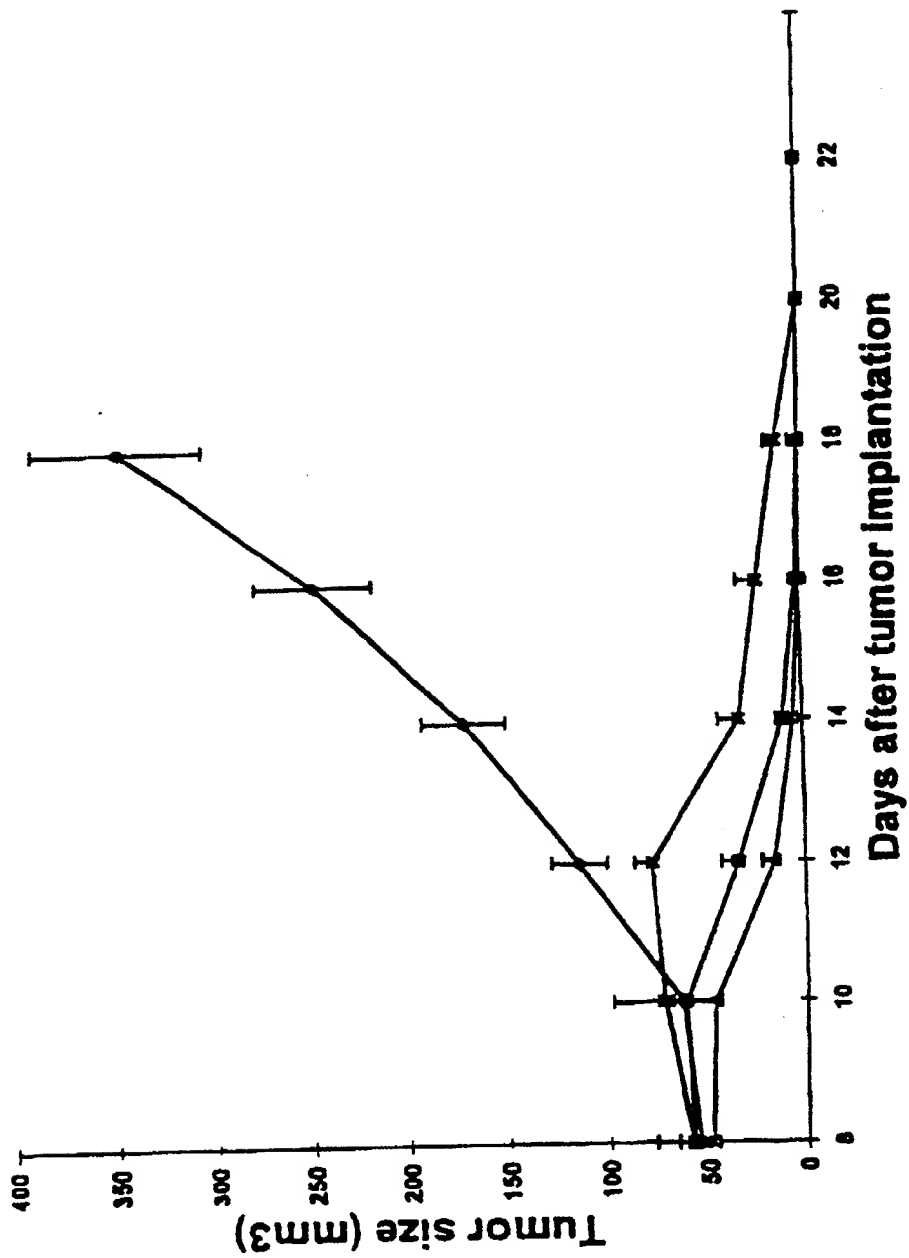
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FIG. 61B



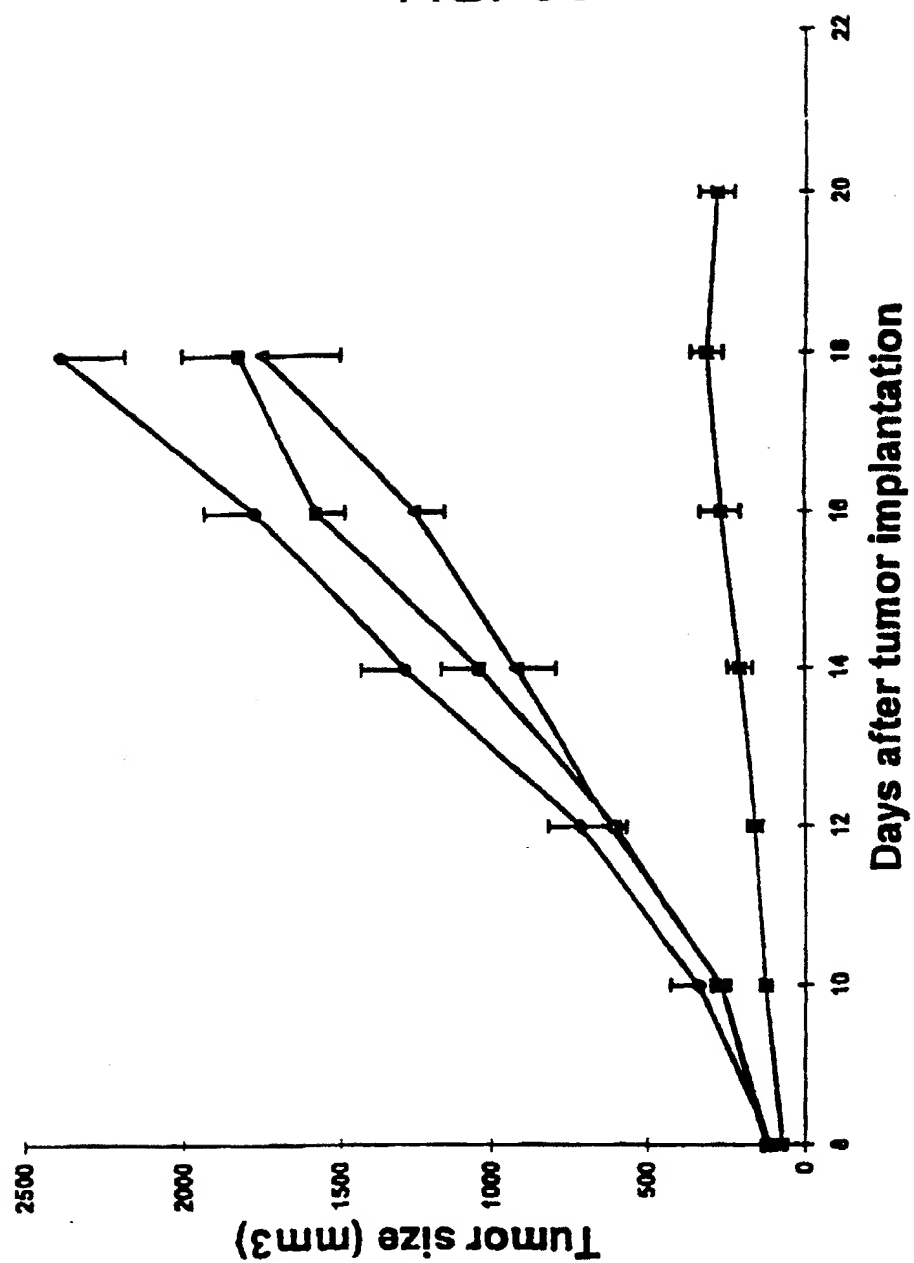
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FIG. 62



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FIG. 63



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FIG. 64

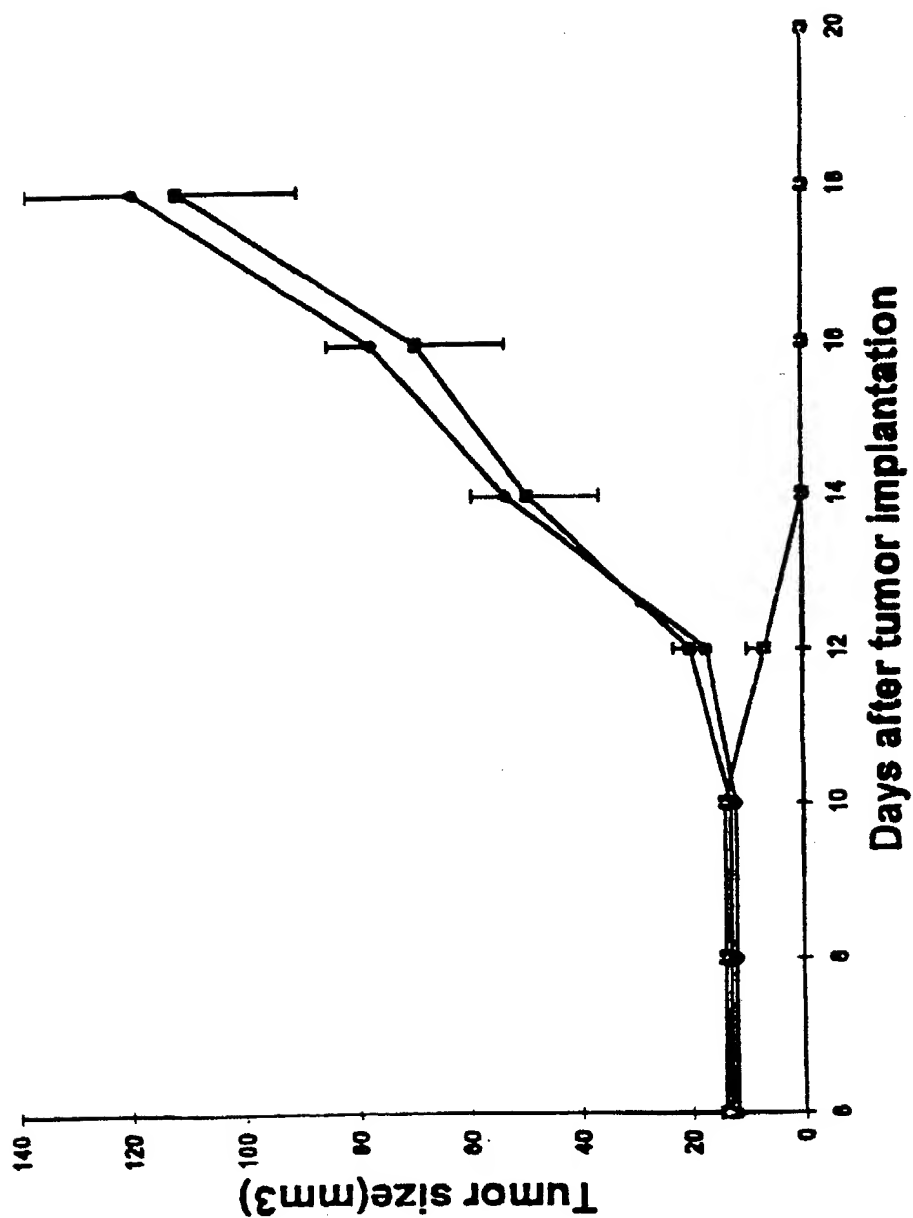
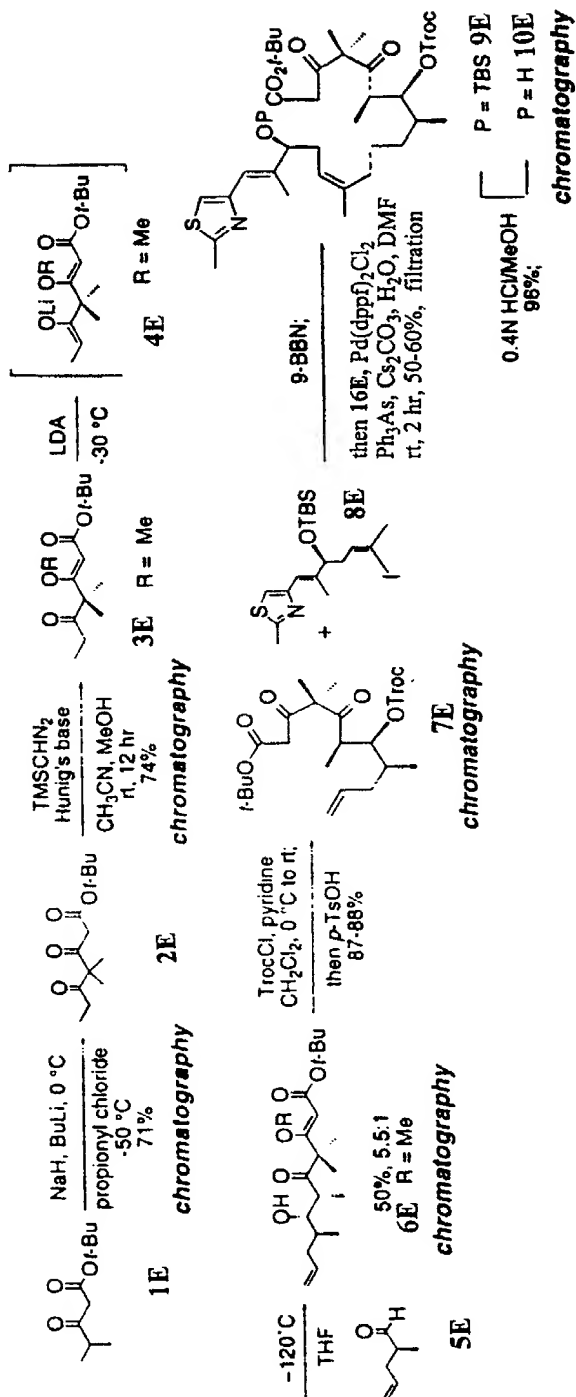
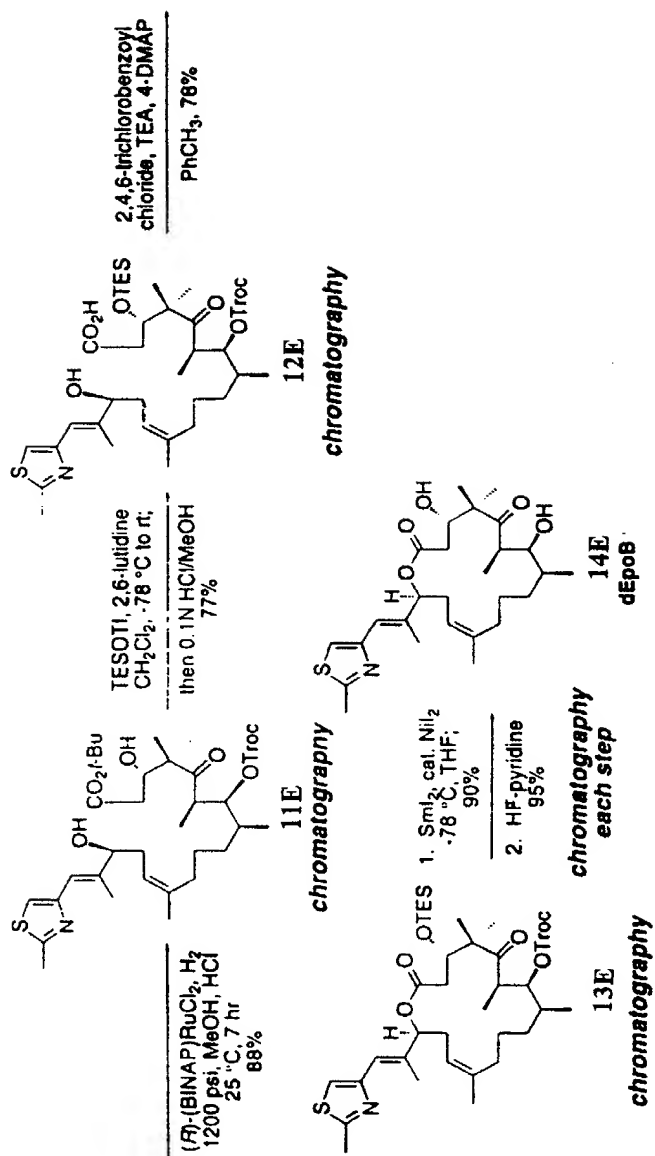


FIG. 65A



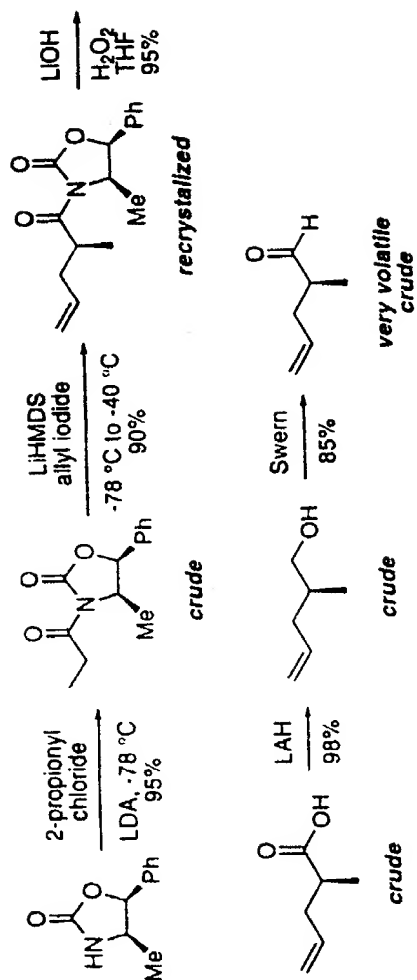
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FIG. 65B



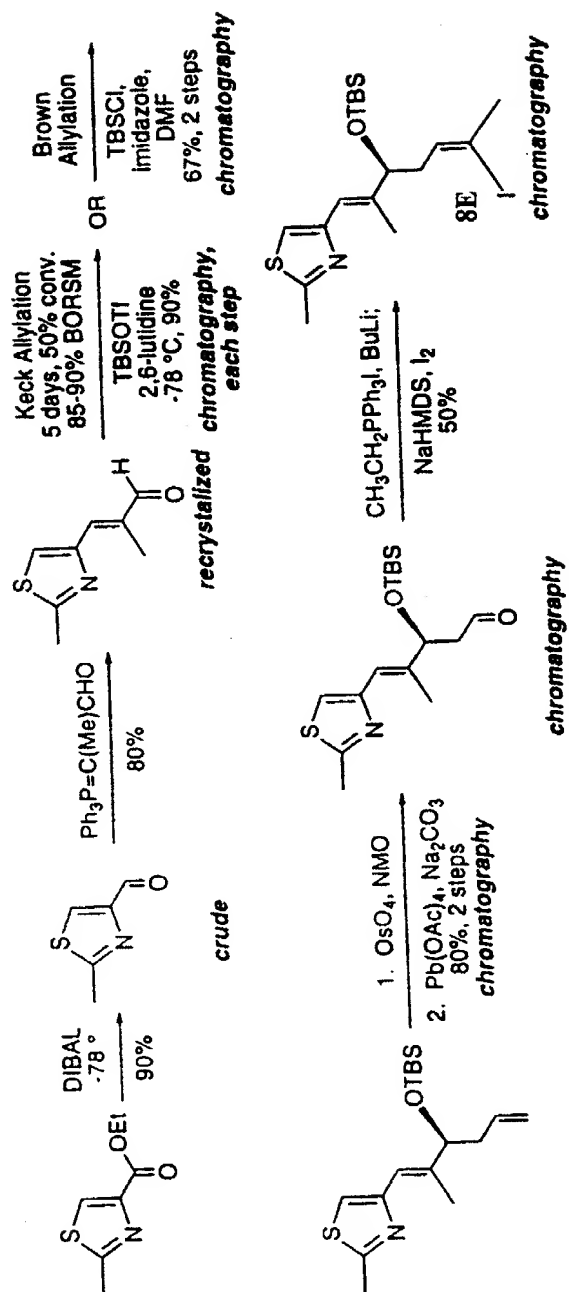
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FIG. 66A



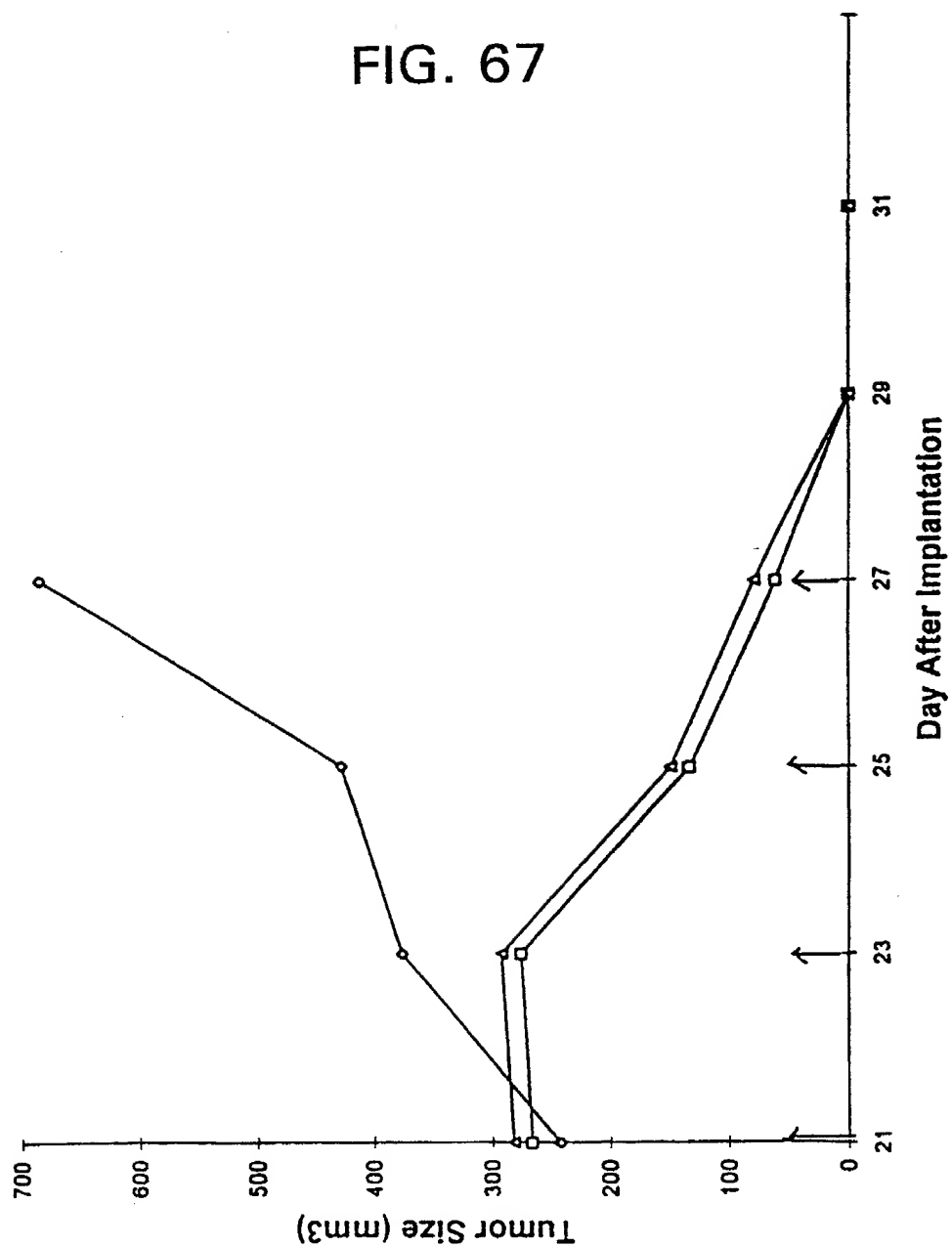
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FIG. 66B



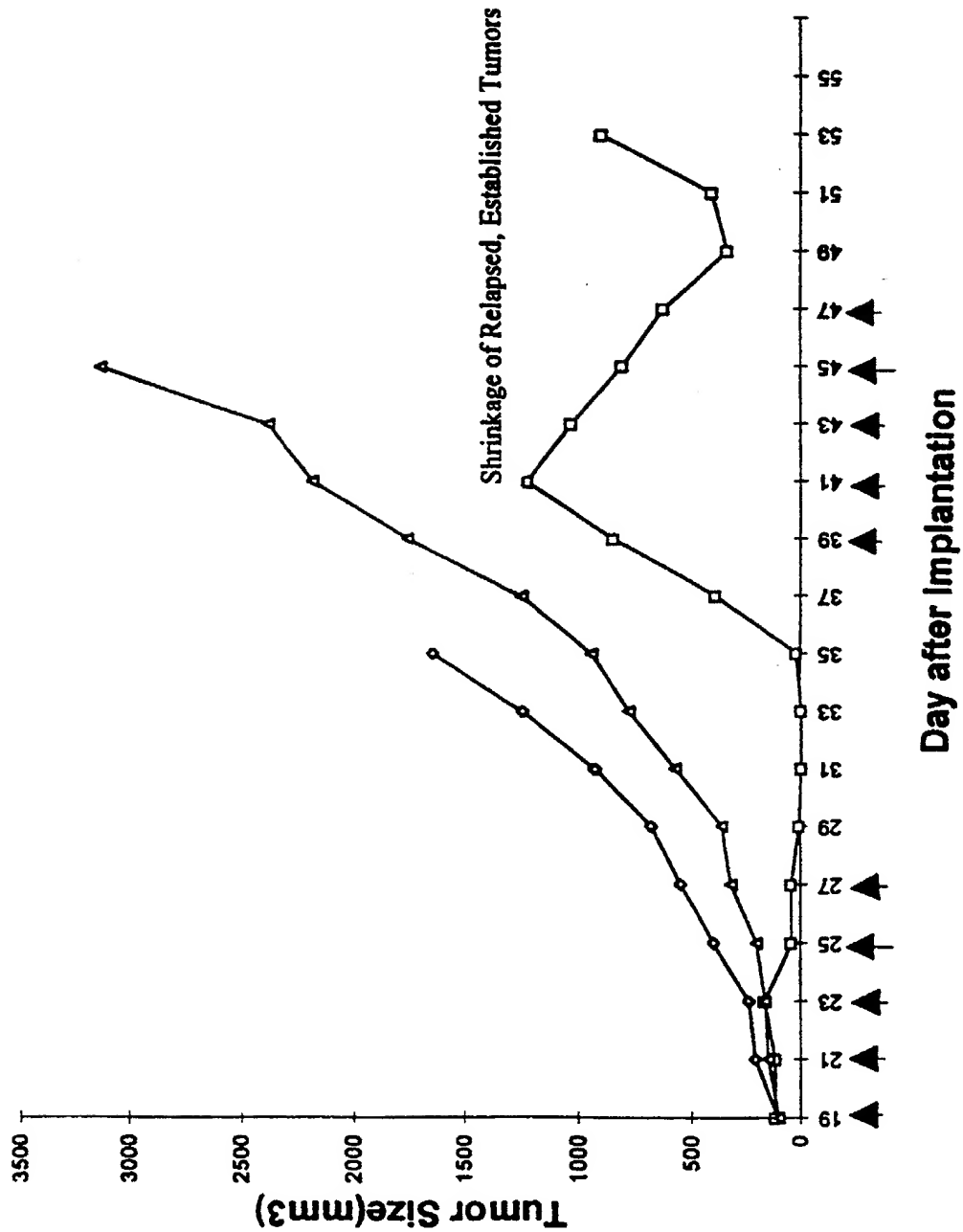
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FIG. 67



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FIG. 68



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FIG. 69

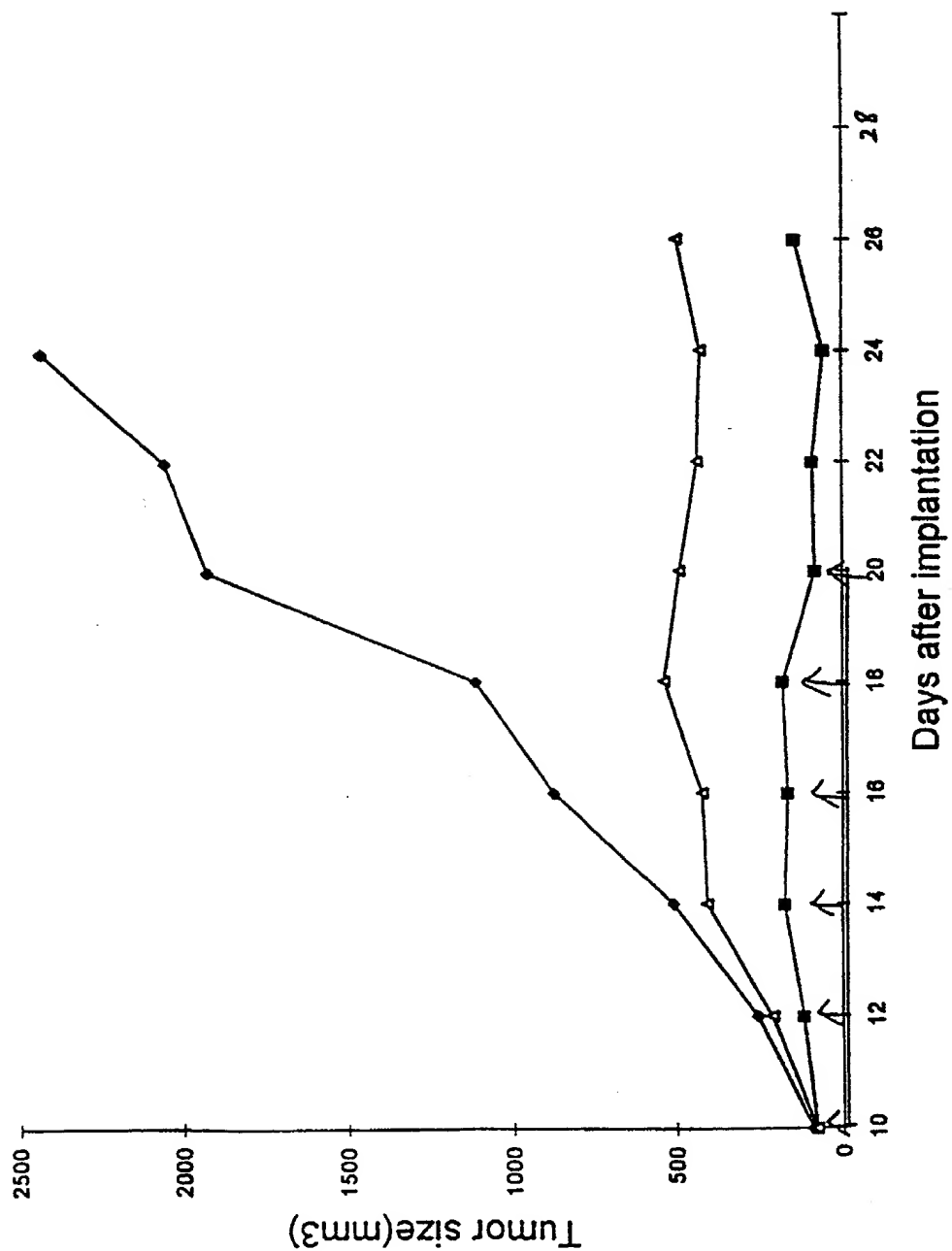


FIG. 70

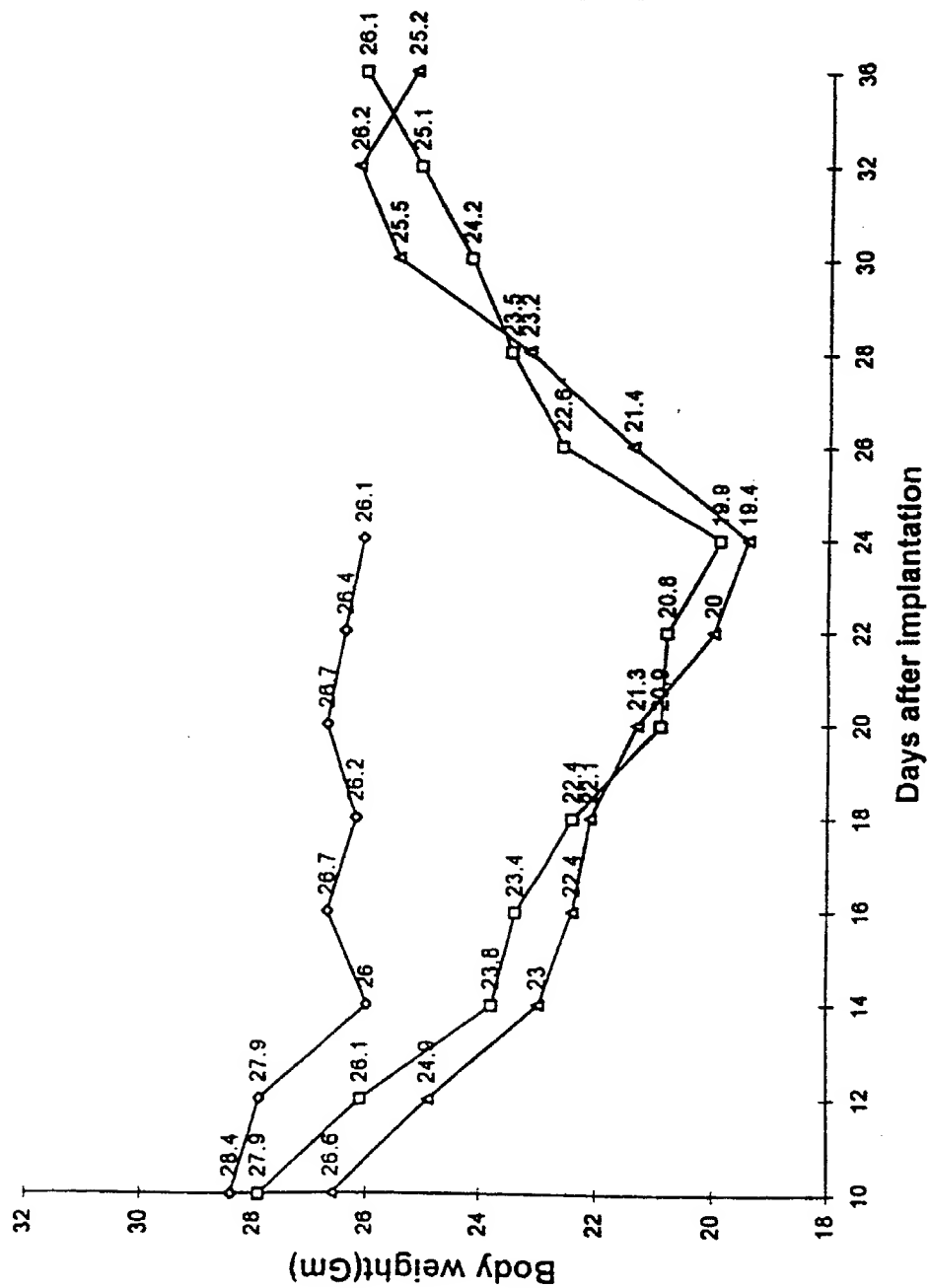
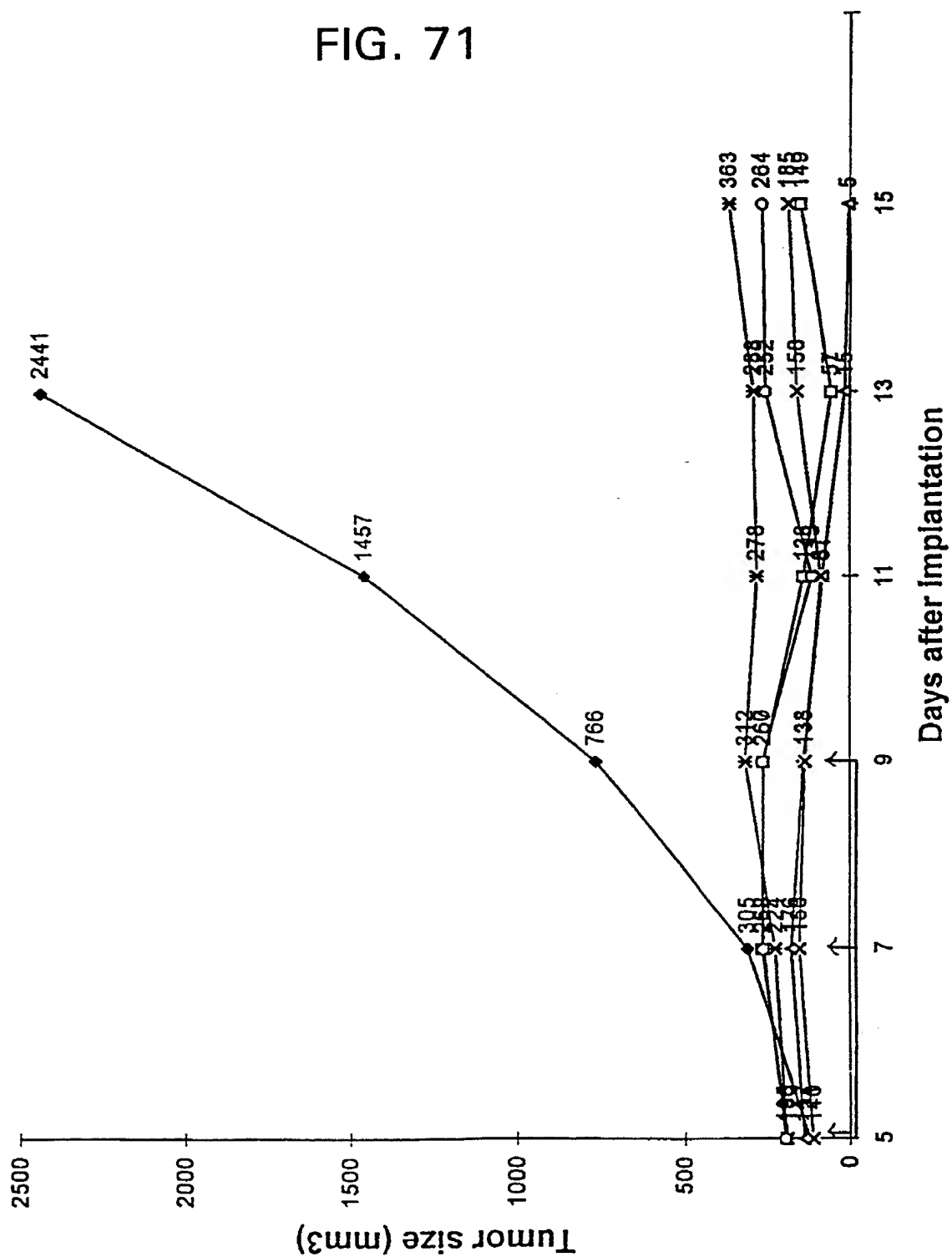
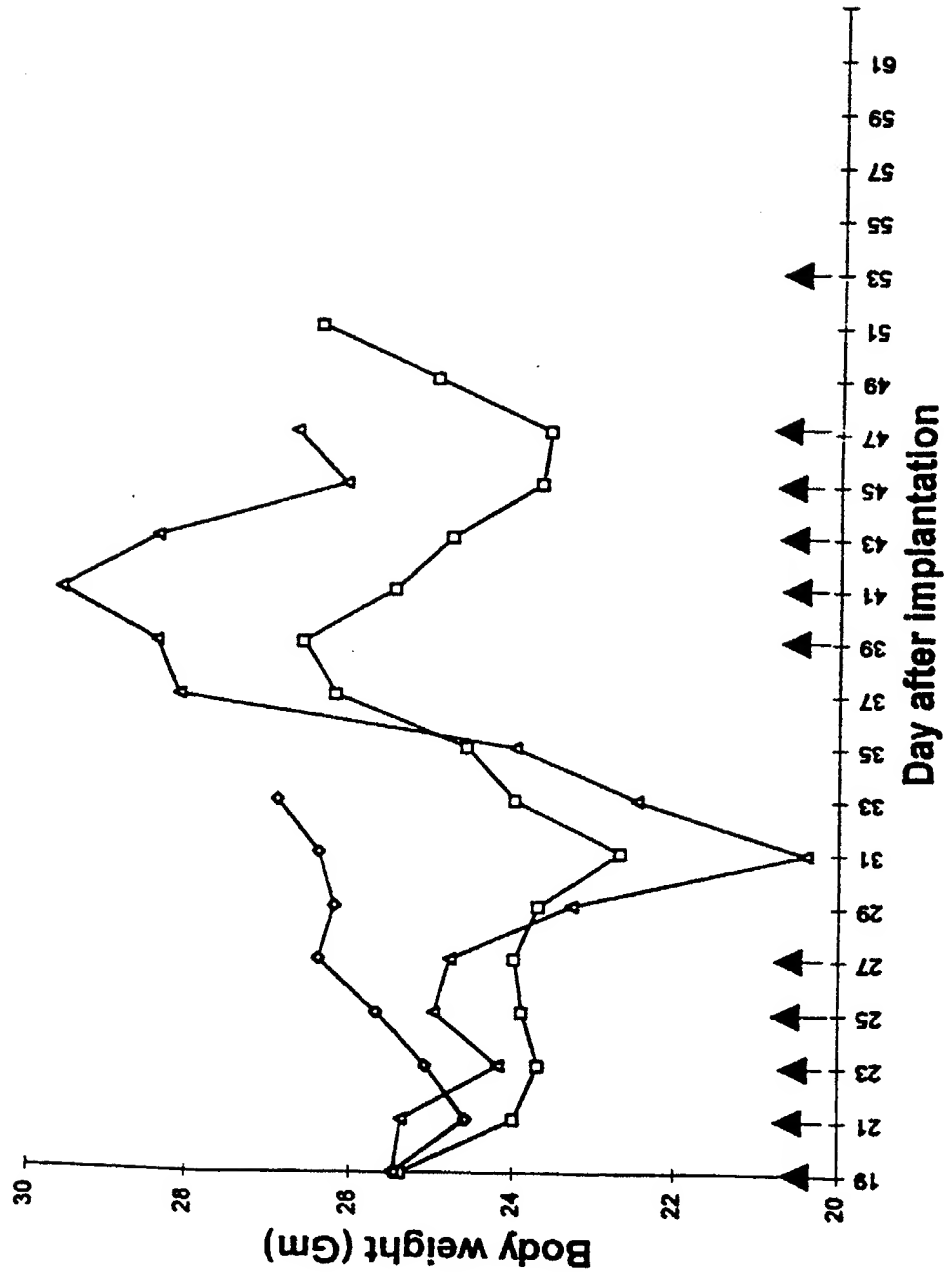


FIG. 71



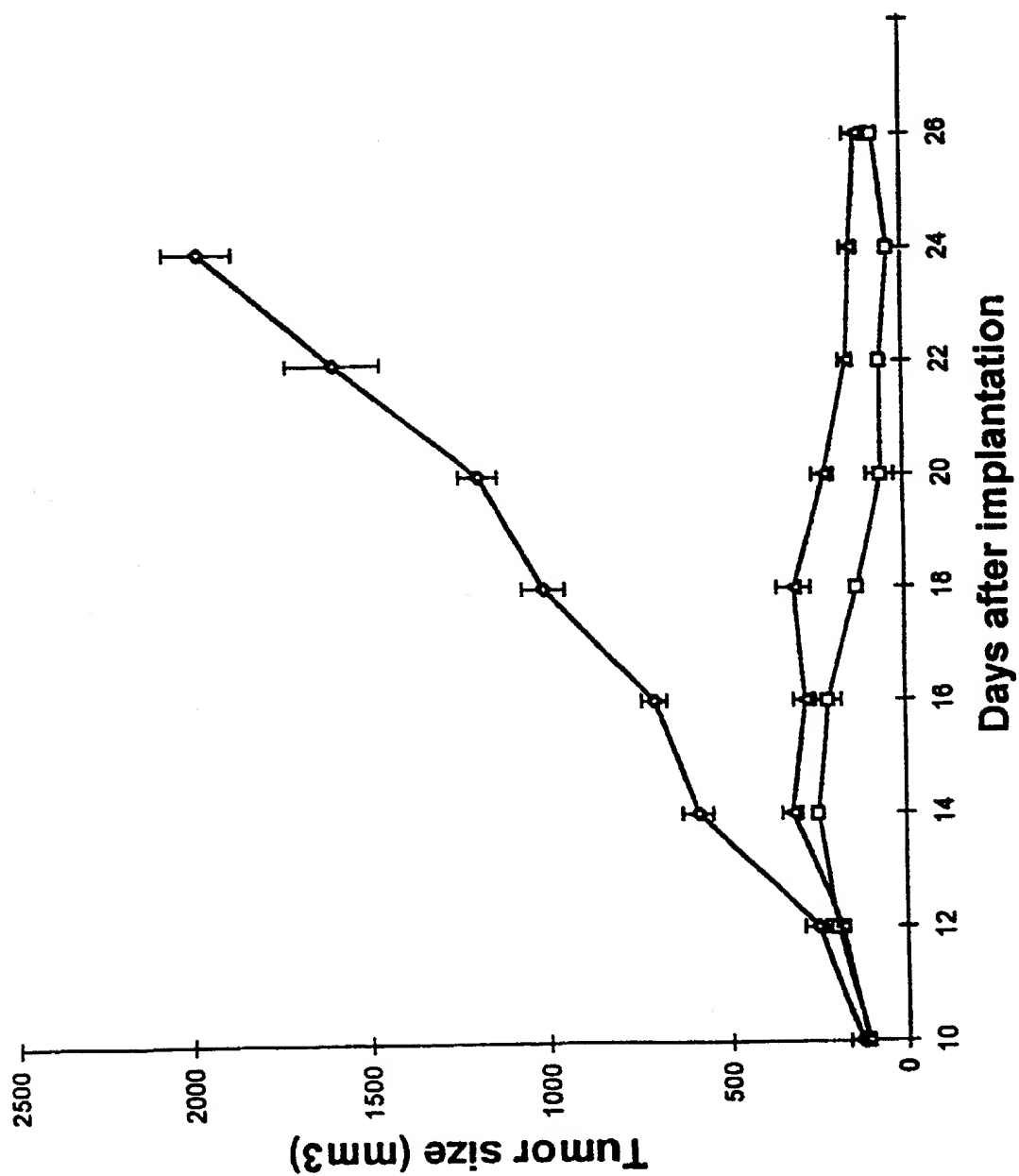
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FIG. 72



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FIG. 73



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FIG. 74

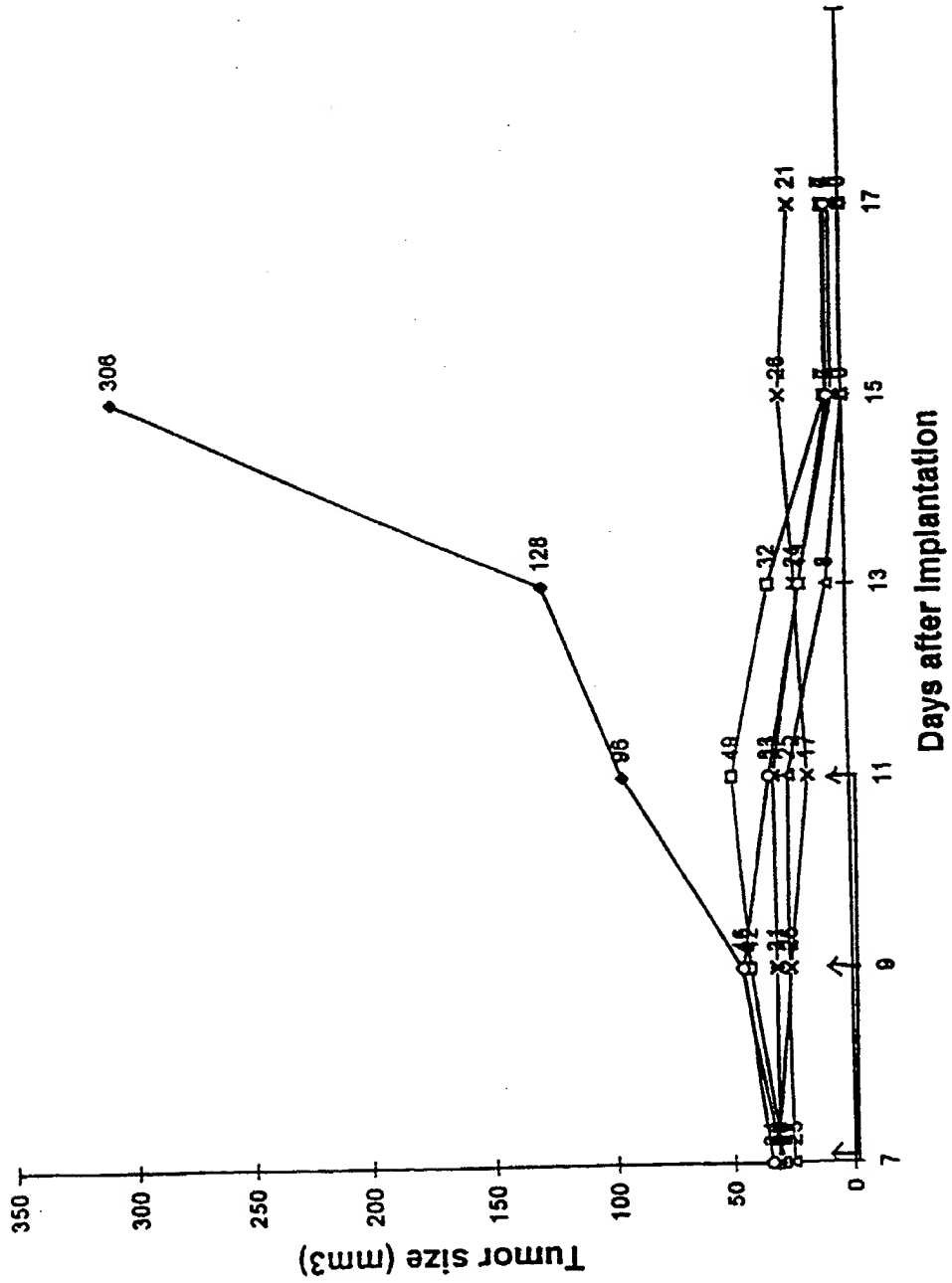
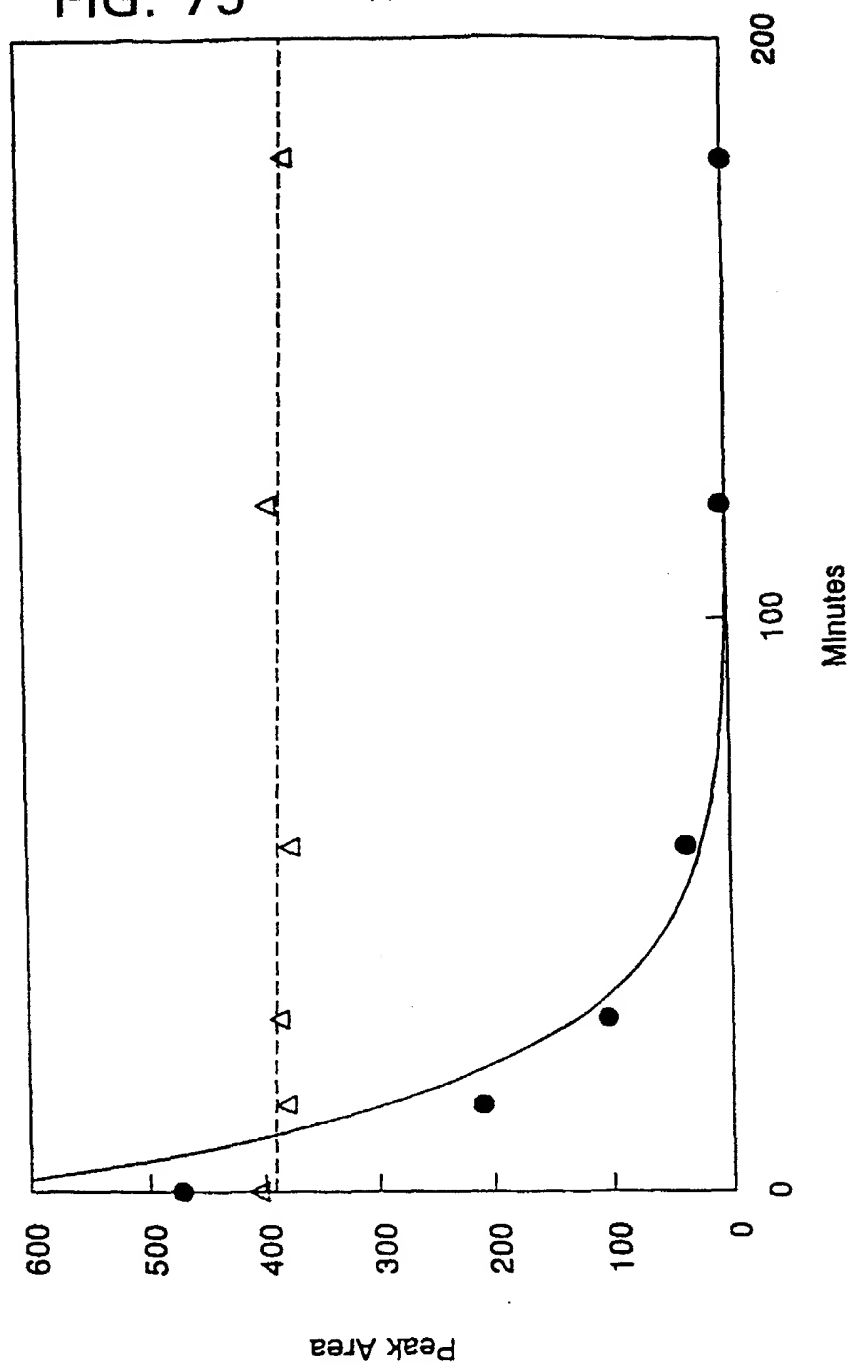


FIG. 75

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SUBSTITUTE SHEET (RULE 26)

INTERNATIONAL SEARCH REPORT

International application No.

PCT/US99/04008

A. CLASSIFICATION OF SUBJECT MATTER

IPC(6) : Please See Extra Sheet.

US CL : Please See Extra Sheet.

According to International Patent Classification (IPC) or to both national classification and IPC

B. FIELDS SEARCHED

Minimum documentation searched (classification system followed by classification symbols)

U.S. : Please See Extra Sheet.

Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched

Electronic data base consulted during the international search (name of data base and, where practicable, search terms used)

CAS ONLINE: structure searches performed on each invention.

C. DOCUMENTS CONSIDERED TO BE RELEVANT

Category*	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
X	MENG et al. Total Syntheses of Epothilones A and B. J. Am. Chem. Soc. June 1997, Vol. 119, No. 42, pages 10073-10092, see page 10088, col. 1, lines 48-63, page 10075, Scheme 1.	35-42
Y		1-8
Y	BALOG et al. Stereoselective Syntheses and Evaluation of Compounds in the 8-Desmethylepothilone A Series: Some Surprising Observations Regarding Their Chemical and biological Properties. Tetrahedron Letters. May 1997, Vol. 38, No. 26, pages 4529-4532, see page 4531.	1-8
Y	NICOLAOU et al. Synthesis of Epothilones A and B in Solid and Solution Phase. Nature. 15 May 1997, Vol. 387, pages 268-272, see page 270, Figure 3.	1-8



Further documents are listed in the continuation of Box C.



See patent family annex.

* Special categories of cited documents:	*T* later document published after the international filing date or priority date and not in conflict with the application but cited to understand the principle or theory underlying the invention
A document defining the general state of the art which is not considered to be of particular relevance	*X* document of particular relevance; the claimed invention cannot be considered novel or cannot be considered to involve an inventive step when the document is taken alone
B earlier document published on or after the international filing date	*Y* document of particular relevance; the claimed invention cannot be considered to involve an inventive step when the document is combined with one or more other such documents, such combination being obvious to a person skilled in the art
L document which may throw doubts on priority claim(s) or which is cited to establish the publication date of another citation or other special reason (as specified)	*G* document member of the same patent family
O document referring to an oral disclosure, use, exhibition or other means	
P document published prior to the international filing date but later than the priority date claimed	

Date of the actual completion of the international search

08 JUNE 1999

Date of mailing of the international search report

29 JUN 1999

Name and mailing address of the ISA/US
Commissioner of Patents and Trademarks
Box PCT
Washington, D.C. 20231

Facsimile No. (703) 305-3230

Authorized officer

JOHN FITZGERALD DOLAN

Telephone No. (703) 308-1235

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PARALEGAL SPECIALIST
CHEMICAL MATRIX

INTERNATIONAL SEARCH REPORT

International application No.

PCT/US99/04008

C (Continuation). DOCUMENTS CONSIDERED TO BE RELEVANT

Category*	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
Y	MARCH, Advanced Organic Chemistry, 2nd Ed., McGraw-Hill, (1977), page 940, section 7-21.	1-8

INTERNATIONAL SEARCH REPORT

International application No.
PCT/US99/04008

Box I Observations where certain claims were found unsearchable (Continuation of item 1 of first sheet)

This international report has not been established in respect of certain claims under Article 17(2)(a) for the following reasons:

1. ☐ Claims Nos.:
because they relate to subject matter not required to be searched by this Authority, namely:

2. ☐ Claims Nos.:
because they relate to parts of the international application that do not comply with the prescribed requirements to such an extent that no meaningful international search can be carried out, specifically:

3. ☐ Claims Nos.:
because they are dependent claims and are not drafted in accordance with the second and third sentences of Rule 6.4(a).

Box II Observations where unity of invention is lacking (Continuation of item 2 of first sheet)

This International Searching Authority found multiple inventions in this international application, as follows:

Please See Extra Sheet.

1. ☐ As all required additional search fees were timely paid by the applicant, this international search report covers all searchable claims.
2. ☐ As all searchable claims could be searched without effort justifying an additional fee, this Authority did not invite payment of any additional fee.
3. ☒ As only some of the required additional search fees were timely paid by the applicant, this international search report covers only those claims for which fees were paid, specifically claims Nos.:
1-8 and 18-42
4. ☐ No required additional search fees were timely paid by the applicant. Consequently, this international search report is restricted to the invention first mentioned in the claims; it is covered by claims Nos.:

Remark on Protest

- ☐ The additional search fees were accompanied by the applicant's protest.
☐ No protest accompanied the payment of additional search fees.

INTERNATIONAL SEARCH REPORT

International application No.
PCT/US99/04008

A. CLASSIFICATION OF SUBJECT MATTER:

IPC (6):

C07D 209/12, 233/54, 263/34, 277/08, 277/22, 277/28, 277/30; A61K 31/42, 31/44, 31/335, 31/415, 31/425; C07F 7/02; C07C 59/185, 69/66

A. CLASSIFICATION OF SUBJECT MATTER:

US CL :

514/336, 365, 374, 397, 415, 450; 544/14, 281.7; 546/14, 334, 335, 341; 548/110, 146, 203, 204, 205, 236, 237, 239, 311.1, 341.5, 415, 450, 501, 510; 549/271; 554/77, 115; 560/174; 562/577, 556/436, 437, 438

B. FIELDS SEARCHED

Minimum documentation searched

Classification System: U.S.

514/336, 365, 374, 397, 415, 450; 544/14, 281.7; 546/14, 334, 335, 341; 548/110, 146, 203, 204, 205, 236, 237, 239, 311.1, 341.5, 415, 450, 501, 510; 549/271; 554/77, 115; 560/174; 562/577, 556/436, 437, 438

BOX II. OBSERVATIONS WHERE UNITY OF INVENTION WAS LACKING

This ISA found multiple inventions as follows:

This application contains the following inventions or groups of inventions which are not so linked as to form a single inventive concept under PCT Rule 13.1. In order for all inventions to be searched, the appropriate additional search fees must be paid.

Group I, claim(s) 1-8, drawn to a method of preparing a deoxyepothilone.

Group II, claim(s) 9-12, drawn to a method of preparing a deoxyepothilone.

Group III, claim(s) 13-17, drawn to a method of preparing a protected deoxyepothilone.

Group IV, claim(s) 18-34, drawn to a method of preparing a hydroxy acid, a hydroxy ester or a hydroxy ketoester deoxyepothilone precursor.

Group V, claim(s) 35-42, drawn to a method of preparing a protected ketoester deoxyepothilone precursor.

Group VI, claim(s) 43-47, drawn to a method of preparing a terminal vinyl enol ether ester.

The inventions listed as Groups I-VI do not relate to a single inventive concept under PCT Rule 13.1 because, under PCT Rule 13.2, they lack the same or corresponding special technical features for the following reasons: this application contains claims directed to more than one method of preparation. These methods of preparation are deemed to lack unity of invention because they are not so linked as to form a single general inventive concept under PCT Rule 13.1. Inventions of Groups I-VI are all methods of preparation for compounds and their intermediates. The inventions are distinct if either or both of the following can be shown: (1) that the process as claimed can be used to make other and materially different product or (2) that the product as claimed can be made by another and materially different process. The present application claims multiple methods of preparation for the compounds and their corresponding intermediates. Therefore, since these compounds can be made by more than one materially different process and the intermediates can be made by more than one materially different process, the inventions of Groups I-VI are deemed to lack unity of invention.